

**AD-A237 443****UNCLASSIFIED****DOCUMENTATION PAGE**Form Approved  
OMB No. 0704-0188

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2. REPORT DATE 15 Dec 89		3. REPORT TYPE AND DATES COVERED Aug 88 - Dec 89	
4. TITLE AND SUBTITLE Technology Insertion (TI)/Industrial Process Improvement (IPI) Task Order No. 1 (Misc Mgf) Data Base Documentation Book for OO-ALC/MANPWW Book 2 of 5		5. FUNDING NUMBERS  Contract	
6. AUTHOR(S)  McDonnell Douglas Missile Systems Company		8. PERFORMING ORGANIZATION REPORT NUMBER  F33600-88-D-0567	
7. PERFORMING ORGANIZATION NAME(S) AND ADDRESS(ES)  McDonnell Douglas Missile Systems Company St. Louis, Missouri 63166		10. SPONSORING/MONITORING AGENCY REPORT NUMBER  F33600-88-D-0567	
9. SPONSORING/MONITORING AGENCY NAME(S) AND ADDRESS(ES)  HQ AFLC/LGME WPAFB OH 45433		11. SUPPLEMENTARY NOTES  Prepared in cooperation with OO-ALC & HQ AFLC	
12a. DISTRIBUTION/AVAILABILITY STATEMENT  Distribution Statement A		12b. DISTRIBUTION CODE	
13. ABSTRACT (Maximum 200 words)  Technology Insertion (TI)/Industrial Process Improvement (IPI) Data Base Documentation Book Volume for OO-ALC/MANPWW (Misc Mgf) Book 2 of 5 This document contains detailed information about layouts equipment and processes for this RCC (Resource Control Center). ←			
14. SUBJECT TERMS MAINTENANCE, DATABASE, TECHNOLOGY INSERTION, EQUIPMENT, AF, AFLC, & MANUFACTURING		15. NUMBER OF PAGES 376	
17. SECURITY CLASSIFICATION OF REPORT Unclassified		16. PRICE CODE	
18. SECURITY CLASSIFICATION OF THIS PAGE Unclassified		19. SECURITY CLASSIFICATION OF ABSTRACT Unclassified	
20. LIMITATION OF ABSTRACT Unclassified			

17 APRIL 89  
GENE EVANS

ANALYSIS OF THE 80/20 LISTING

A-1		23
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INSPECTED		5



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8:12 FRIDAY, APRIL 7, 1989 1

ALC SASCAN CNTL(O08020P)

QGDEN 80/20 SORTED BY TOTAL HRS

N S N	P C N	O B S E R	P G P S	P G P P	P G W S	P G W P	P N N A S P	P R A S	P R A P	P R B S	P R B P	P R C S	P R C P	P W S	P W P	L T D T	C U M
000F0004F	A4141N						82 0.0026							45 0.0057	45 0.0055	55.22	0.0002725
1560012452818WF	M1069K						70 0.0033							35 0.0022	35 0.0022	70.09	0.0006183
4210P8633369	M1641K													17 0.0131	17 0.0131	87.24	0.0010487
1450010618477A8	M3009K													18 0.0151	18 0.0151	305.20	0.0025545
1730P8852369-10	M4586K													3 0.0416	3 0.0416	239.52	0.0037362
2330P8516153	M4631D													22 0.0111	22 0.0111	659.88	0.0081736
8140011515345	M4823K															176.07	0.0090423
5315007575890LE	M8055K						226 0.0005									115.08	0.0096100
1430ND028568GAH	M6118K															93.49	0.0100713
1620012352270	M5276K						43 0.0054									271.39	0.0114102
3920000625516AH	M5366K															115.80	0.0119815
1620012697856LE	M7202K															172.05	0.0128304
1450ND028644GAH	M7871K															244.28	0.0140356
1630005022994	M8366K															78.88	0.0144297
3120P855928-03	M8662K															990.91	0.0193185
9999POV10A	T1302A															447.02	0.0215240
LOG-00008492028	T1384I															53.10	0.0217860
1620PC141CAIPLG	T1385Q															125.16	0.0224035
1620PC141CAIPLG	T1386Q															122.64	0.0230209
9999POOV0010A	T1434A															118.95	0.0242129
1337009574611	T1531I															82.84	0.0251656
1337000784250	T1532I															17.45	0.0254517
1337011451863	T2532A															89.21	0.0258918
SYS-00005140002	T2709I															180.54	0.0267820
1300PGR-TEST288	T2733I															299.49	0.0282601
1300PGROUNDTEST	T4582Q															1559.04	0.0359520
LOG-00008492005	T4885I															150.69	0.0366954
1300PGROUNDTEST	T4971Q															369.58	0.0385188
1300PGROUNDTEST	T4989Q															239.36	0.0396998
1630005470116	T5530I															237.32	0.0408706
9999P-LGM118A	T5733M															80.71	0.0412688
1630005756750	T5736I															707.24	0.0447582
1630ND028478G	T5773J															275.26	0.0461162
1630ND026165G	T5797J															630.31	0.0492260
	T5802J															251.33	0.0504660
1630ND028498G	T5811J															187.50	0.0513910
1630ND028432G	T5817J															239.36	0.0525720
1630ND026166G	T5821J															247.34	0.0537923
1630ND028431G	T5822J															263.30	0.0550913
	T5846J															163.56	0.0558982
162000824080	T6254A															234.56	0.0570555
1620002421514	T6295I															618.24	0.0610157
1620006133512	T6912A															341.83	0.0617922
4935P8116	T7266Q															498.67	0.0642574
	T7333Q															1906.90	0.0761307
1620010054192	T7576A																









ALC SASCAN CNTL (008020P)

ORDEN 80/20 SORTED BY TOTAL MRS

NSN	P C H	O P E R S	O B S E R	P G P S	P G P P	P G W S	P G W P	P N A S	P N A P	P R A S	P R A P	P R B S	P R C S	P R C S	P W S	P W P	P W P	L T A T	C U M
1620000271193	72572A	12	19	91	0.0025	133	0.0016	115	0.0017	134	0.0008	35	0.0074	50	0.0050	125	0.0007	323	0.764472
16200004325851	72377A			49	0.0055	61	0.0047	88	0.0025	134	0.0008	31	0.0090	85	0.0027	71	0.0025	496	0.766920
16300004649162	72398A	15	15	85	0.0028	28	0.0088	93	0.0023	39	0.0084			95	0.0023			743	0.769106
16200001791082	74510A	87	7	141	0.0013	95	0.0028	152	0.0010	19	0.0156	82	0.0020	82	0.0040	35	0.0018	1050	0.772761
16200001677495	74521A			144	0.0060	21	0.0104	104	0.0020	13	0.0200	20	0.0146	34	0.0076	48	0.0054	1894	0.777921
162000018877449	74521A							34	0.0066			17	0.0183					272	0.787288
16200002408005	74524A																	341	0.788630
16200002482005	74524A			37	0.0063	22	0.0097	17	0.0095	12	0.0230	14	0.0157	14	0.0157	51	0.0047	2235	0.801339
1620000427877	74527A	2	2	183	0.0062	14	0.0134	47	0.0049	2	0.0494	26	0.0108	10	0.0189			3785	0.820014
16200004719659	74528A			124	0.0005	180	0.0008	223	0.0005	48	0.0054			216	0.0006			312	0.821551
16200009746793	74553A			54	0.0016	84	0.0029	132	0.0012	76	0.0026			122	0.0017			340	0.823230
16300004100658	74568A			107	0.0049	71	0.0035	242	0.0004	51	0.0051	57	0.0033	304	0.0002	116	0.0009	551	0.825951
16200001486496	74652A			18	0.0021	154	0.0011	148	0.0011	116	0.0010	38	0.0065	82	0.0030	143	0.0008	346	0.827659
16200001791435	74805A				0.0121	58	0.0049	49	0.0047	44	0.0059	38	0.0065	24	0.0106	69	0.0027	1475	0.834936
1005000586753	74805A											38	0.0017	5	0.0278	14	0.0173	1230	0.841008
1620011627542	83317A	5	2	110	0.0020	78	0.0031	126	0.0033	111	0.0011			112	0.0020	76	0.0022	344	0.842703
16300C11826267	90101A	166		3	0.0403	4	0.0400	37	0.0058	1	0.0532	137	0.0004	97	0.0022			5903	0.871825
1620000222923	94332A							91	0.0024	74	0.0027	68	0.0026	68	0.0036			246	0.873038
16500002193601E	98929A							215	0.0006	221	0.0001							176	0.873907
																		*****	
																		0 8564	177130
																		*****	

# **BREAKDOWN OF PCNS FOR 80/20 LIST**

<u>TYPE OF WORK</u>	<u>NO. OF PCNS</u>	<u>NO. OF WCDS</u>
MISTR ITEMS OWNED BY FCCS TO BE PROCESS CHARACTERIZED	117	1095
TEMPORARY	37	37
MANUFACTURE	15	15
PDM	13	13
MISTR ITEMS OWNED BY ARMAMENT	10	52
MISTR ITEMS OWNED BY HYDRAULICS	23	42
TDY	1	1

# 80/20 MATRIX OGDEN, UTAH

PCN	NO. OF WCDS	NOUN	NO. OF COMPLETIONS			
			FY89-1	FY89-2	FY88-3	FY88-4
16019A	27	F-4 N.L.G.	20	6	2	7
17565A	19	C-141 M.L.G.	26	20	25	34
74524A	12	C-141 M.L.G.	24	8	20	6
16283A	12	C-141 M.L.G.	30	18	31	34
74553A	1	C-141 M.L.G.	25	8	3	30
74516A	1	C-141 M.L.G.	23	28	4	13
69136A	1	C-141 M.L.G.	53	32	69	67
74527A	12	C-141 M.L.G.	25	14	34	37
90101A	9	C-5A&B WHEEL (M)	230	300	265	294
72898A	7	C-5A&B WHEEL (M)	45	26	34	31
17567A	8	KC-135 N.L.G.	-	-	-	1
69354A	6	KC-135 N.L.G.	30	37	42	38
17357A	4	KC-135 N.L.G.	26	26	35	25
17467A	1	KC-135 N.L.G.	26	26	35	25
15359A	4	KC-135 M.L.G.	93	18	584	144
15468A	2	KC-135 M.L.G.	532	100	226	481
15592A	3	KC-135 M.L.G.	132	73	13	81
15387A	4	T-38 BRAKE ASSY	24	17	27	10
15162A	5	KC-135 BRAKE ASSY	74	94	78	48
15054A	5	KC-135 BRAKE ASSY	44	66	55	13
15603A	1	KC-135 BRAKE ASSY	109	100	154	60
19844A	11	C-130 N.L.G.	33	10	10	30
<b>TOTAL</b> 22 (23)	155 (62)	NOT ON 80/20 BUT PART OF AS-IS TO THE ACTUAL WORKLOAD	1624	1027	1746	1509

# 80/20 MATRIX OGDEN, UTAH

PCN	NO. OF WCDS	NOUN	NO. OF COMPLETIONS			
			FY89-1	FY89-2	FY88-3	FY88-4
26337A	30	F-15 M.L.G.	6	4	9	9
26338A	30	F-15 M.L.G.	12	5	9	5
74568A	5	A-7 BRAKE ASSY	34	18	-	18
25425A	3	A-10 MAIN WHEEL ASSY	53	45	33	20
15686A	3	A-10 NOSE WHEEL ASSY	48	70	19	19
15139A	3	B-52 MAIN WHEEL ASSY	33	3	17	61
15526A	3	B-52 MAIN WHEEL ASSY	38	-	50	38
69595A	3	B-52 MAIN WHEEL ASSY	108	11	274	237
15746A	3	C-141 NOSE WHEEL ASSY	21	23	105	114
62922A	3	C-141 NOSE WHEEL ASSY	14	20	29	22
62923A	3	C-141 NOSE WHEEL ASSY	44	50	104	126
62927A	3	C-141 NOSE WHEEL ASSY	183	146	107	129
19588A	4	F-15A&B NOSE WHEEL ASSY	98	100	124	211
26183A	4	F-15A&B NOSE WHEEL ASSY	94	94	42	1
69794A	4	F-15A&B NOSE WHEEL ASSY	35	16	76	-
15641A	2	F-4 BRAKE HOUSING	122	58	21	163
17402A	24	F-15 N.L.G.	9	17	31	23
17142A	26	B-52 M.L.G.	19	14	19	20
17143A	26	B-52 M.L.G.	19	19	20	32
69855	1	B-52 M.L.G.				
16836	25	F-4 M.L.G.	41	29	68	69
16837	25	F-4 M.L.G.	44	22	46	70
<b>TOTAL</b>						
22	230		1090	765	1212	1412
(27)	(141)	NOT ON 80/20 BUT PART OF AS-IS TO THE ACTUAL WORKLOAD				

# 80/20 MATRIX OGDEN, UTAH

PCN	NO. OF WCDS	NOUN	NO. OF COMPLETIONS			
			FY89-1	FY89-2	FY88-3	FY88-4
74521A	21	C-141 N.L.G.	15	23	18	9
74528A	1	C-141 N.L.G.	12	4	10	10
17575A	59	C-5A M.L.G.	5	3	6	3
17576A	59	C-5A M.L.G.	4	4	7	5
17577A	59	C-5A M.L.G.	3	3	2	5
17578A	59	C-5A M.L.G.	3	2	4	1
74652A	6	C-5A M.L.G.	12	-	1	-
74692A	26	C-5A M.L.G.	6	13	-	1
72877A	38	C-5A N.L.G.	2	2	3	2
15295A	4	F-111 BRAKE	46	42	44	65
15519A	1	F-111 BRAKE	22	94	57	35
15583A	6	F-111 BRAKE	8	1	6	9
68521A	3	C-130 NOSE WHEEL (NAVY)	94	38	37	45
62405A	3	C-130 NOSE WHEEL (NAVY)	50	16	32	115
15757A	3	C-130 NOSE WHEEL (NAVY)	48	60	31	48
16123A	10	C-130 BALL SCREW ASSY	24	51	35	35
17527A	14	A-70 M.L.G.	17	6	12	19
17595A	14	A-70 M.L.G.	-	1	-	-
25874A	4	F-16 M.L.G. BRAKE ASSY	81	205	110	49
26411A	1	F-16 M.L.G. BRAKE ASSY	200	240	400	202
15161A	5	C-141 BRAKE ASSY	19	18	63	63
<b>TOTAL</b>			665	826	878	721
21	359					
(30)	(81)					
		NOT ON 80/20 BUT PART OF AS-IS TO THE ACTUAL WORKLOAD				



# 80/20 MATRIX OGDEN, UTAH

PCN	NO. OF WCDS	NOUN	NO. OF COMPLETIONS			
			FY89-1	FY89-2	FY88-3	FY88-4
26642A	23	F-16 N.L.G.	7	11	-	2
42626A	23	B-52 TIP	5	3	2	5
83317A	6	F-16 NLG UPPER DRAG	8	4	-	21
		BRAKE ASSY				
17478A	19	T-38 N.L.G.	26	20	10	30
17451A	9	KC-135 M.L.G.	24	12	21	14
17313A	10	KC-135 M.L.G.	11	14	30	18
17259A	11	KC-135 M.L.G.	25	16	24	26
17327A	10	KC-135 M.L.G.	28	23	32	30
17347A	4	KC-135 M.L.G.	15	27	55	33
17348A	4	KC-135 M.L.G.	35	26	38	34
17245A	1	KC-135 M.L.G.	74	47	88	100
17407A	1	KC-135 M.L.G.	59	33	47	46
69554A	1	KC-135 M.L.G.	45	28	1	-
69657A	12	KC-135 M.L.G.	15	10	1	1
16915A	6	KC-135 M.L.G.	20	25	-	1
69549A	1	KC-135 M.L.G.	40	50	1	50
69354A	14	KC-135 M.L.G.	30	37	42	38
17357A	10	KC-135 M.L.G.	26	26	35	25
15359A	5	KC-135 M.L.G.	93	18	584	144
15468A	4	KC-135 M.L.G.	532	100	266	481
15523A	3	FB-111 MAIN WHEEL ASSY	13	19	-	-
25737A	13	F-16 M.L.G.	29	29	22	35
26111A	1	F-16 M.L.G.	10	24	4	24
<b>TOTAL</b>	<b>191</b>		<b>1174</b>	<b>602</b>	<b>1303</b>	<b>1158</b>

# 80/20 MATRIX OGDEN, UTAH

PCN	NO. OF WCDS	NOUN	NO. OF COMPLETIONS			
			FY89-1	FY89-2	FY88-3	FY88-4
25874A	9	F-16 HOUSING BRAKE ASSY	81	205	110	49
26413A	1	F-16 HOUSING BRAKE ASSY	300	360	600	303
26411A	1	F-16 BRAKE ASSY	200	240	400	202
15752A	7	A-10 BRAKE ASSY	36	54	50	21
15068A	5	B-52 BRAKE ASSY	48	74	129	113
36192A	1	B-52 BRAKE ASSY	59	40	122	80
17474A	22	T-38 M.L.G.	10	4	2	-
17476A	21	T-38 M.L.G.	6	7	8	-
17568A	2	T-38 M.L.G.	100	-	-	-
15327A	7	C-130 BRAKE ASSY	35	29	48	64
15728A	2	C-130 BRAKE ASSY	62	19	2	3
26560A	1	F-15 A/B BRAKE ASSY	444	210	162	120
26559A	1	F-15 A/B BRAKE ASSY	592	280	216	160
15485A	9	F-4 MAIN WHEEL ASSY	50	225	216	54
16267A	3		57	8	88	39
16266A	3		129	6	79	62
17354A	24	F-111 N.L.G.	9	9	4	7
19937A	21	A-10 N.L.G.	16	10	12	8
15752A	2	A-10 N.L.G.	36	54	50	21
15698A	9	C-5A M.L.G. BRAKE ASSY	7	20	22	5
72896A	1	C-5A M.L.G. BRAKE ASSY	199	60	-	-
<b>TOTAL</b> 16	95		2567	1914	2320	1311

# OPEN TEMPORARY JOBS

PCN	DESCRIPTION	QTY	DATE PLANNED
T6254A		30	880930
T7601I		778	880530
T6295I		117	880404
T6912A		30	880930
T5736I		1000	880601
T5797J		2500	880331
T5811J		3206	871231
T5822J		600	880331
T5330		1000	880401
T5733N		1280	880330
T4989Q		400	881231
T4452Q		480	890331
T4582Q		400	890331
A4141N		56	880930
T2733I		50	841231
T1384I		55	841231
T2532A		20000	862701

# CLOSED TEMPORARY JOBS

PCN	QTY	PLANNED DATE OUT	CLOSED DATE
T1385Q	2	15-Nov-88	3-Feb-89
T1386Q	2	15-Nov-88	3-Feb-89
T1434A	450		
T5493I	200	1-Aug-88	30-Jan-89
T5773J	2385	27-Nov-87	30-Jan-89
T5802J	1000	17-Oct-88	10-Jan-89
T5817J	1000		27-Feb-89
T5821J	2500	17-Dec-87	
T7576G	1	17-Jan-87	18-Nov-89
T7582I	2	23-Nov-87	17-Feb-89
T9355I	20	23-Sep-88	27-Dec-89

# PERCENT OF OTHER WORKLOAD FOR RCC

(80/20 LISTING)

RCCs

JOB TYPES	MANPGP	MANPGW	MANPHA	MANPRA	MANPRB	MANPRC	MANPWW
TEMPORARY	13.72	2.35	15.11	1.40	1.05	1.35	1.05
MANUFACTURE	0.00	0.00	0.92	0.00	4.51	2.74	12.50
PDM	1.00	0.00	22.79	0.04	0.07	4.39	22.44
ARMAMENT	0.00	0.23	1.26	0.04	0.03	4.18	2.38
HYDRAULICS	0.00	0.05	7.00	1.11	2.67	3.88	13.99
MISCELL. (Hooks, Brakes, Landing Gears)	85.28	97.37	52.92	97.41	91.67	83.46	47.64

DISTRIBUTION: NAME (4)

SEQUENCE: PU/PTC/CN/JD/OPENR/ROC/FC

PAGE BREAK: PU/PTC/CN/JD

AG004L-L3A-DI-MAA

TEMPORARY JOB RECORD

AS OF 88-08-23 PAGE 001

REQUEST CUST  
NUMBER ID

END ITEM  
IDENTITY

DATE NO P  
NEED MI SC PRI AUTHORITY

CTRL J JON D UD OTHER DIR P  
FORM NR D SWF PC M COST C1

II PRICE  
OR RATE

ENMS1148 ENMSP 000F0004E

98 MBEFEW 84228 880920 M 3 02 EG-D-EFY/001

808J A4141 M 84A N EA 2381.00 A

88.00

F OPER BS T SK  
ROC C NR PI GO IC CD

ORIG TOT STD ROC  
OCL HOURS RATE

PART  
NUMBER

-----OPERATION DESCRIPTION-----

STD EXP STD INV  
MAT COST MAT COST

MATERIAL  
IDENTIFICATION

MANUF  
CODE

QTY QUANT

STOCK C EXPENSE  
PRICE C MAT COST

INV MAT  
COST

ANPMA 2 00001 S 1 DS 1.00 56 86 41.940

2348.64

TOT TO (AIRD EGYPT FOR MDI SUPPORT.

.00

.00

POB COPY SIGNATURE:

SCHEDULER SIGNATURE:

QUALITY SIGNATURE:

JOB SUMMARY: CUST EST

TOT PLN'D HOURS: 56.00

56.00

PLAN PT

ONS C

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PHONE BLOS

LOCATION

ROC

POB S

SECT D

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PHONE BLS

NAME

DAVID

MAIL

SYMB

PHONE BLOS

LOCATION

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SECT D

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PHONE BLS

## PROCESS CHARACTERIZATION OF RCCS

1. MODEL LANDING GEAR, BRAKES, AND WHEELS AS THE MAJOR COMPONENTS THRU THE SEVEN RCCS AS MAJOR FAMILY GROUPINGS
2. TREAT ALL OTHER WORKLOADS T, M, & PDM JOBS THRU THE SHOPS AS A MANPOWER CONSTRAINT -- MANPOWER IS NOT AVAILABLE AS A PERCENT XX TO WORK ON BRAKES, WHEELS, AND LANDING GEAR BECAUSE THEY ARE WORKING OTHER JOBS.
3. IDENTIFY ANY OTHER WORKLOAD THAT MAY REQUIRE EQUIPMENT AND CONSTRAINT THE EQUIPMENT FOR THE TIME NEEDED TO PERFORM THE OTHER WORKLOAD AS A PERCENT XX THAT THE EQUIPMENT IS FOR OTHER USE.
4. WORKLOAD WILL BE CALCULATED FROM THE DATA FOR THE FAMILY GROUPINGS TO GENERATE THE "AS-IS" CONDITION OF THE WORKLOAD COMPLETED FOR EACH QUARTER.
5. PERFORM INDUSTRIAL ENGINEERING ASSESSMENT OF ALL RCC - OVERVIEW OF RCCS - PARA. 3.1.1.1 OF SOW.

## PROPOSED BRAKE GROUPINGS

<u>FAMILY NO</u>	<u>FAMILY CHARACTERISTICS</u>	<u>AIRCRAFT</u>
1	MAGNESIUM HOUSING - STEEL BRAKE	"B-52" A-37, F-106 T-33, F-100
2	ALUMINUM HOUSING - STEEL BRAKE	"KC-135" A-7D, T-38, T-39, F-111, F-5, A-10, C-130, C-141, E-3A
3	ALUMINUM HOUSING - BERYLLIUM BRAKE	C-5A
4	ALUMINUM HOUSING - CARBON BRAKE	C-5B, F-15, F-16



## **BRAKES**

### **NOTES: (1) FOREMAN, MAX BATE**

- (2) C-130 HAS EITHER A SINGLE ROTOR OR MULTIPLE ROTOR BRAKES (MULTIPLE ROTOR BRAKES CAN BE GROUPED IN THE KC-135 GROUPING, SINGLE ROTOR BRAKE TO BE CHARACTERIZED AS A SEPARATE ENTITY)
- (3) KC-135 HAS EITHER FOUR ROTORS OR FIVE ROTORS
- (4) F-4 ONLY THE HOUSING IS REFURBISH
- (5) F-16 HAS SOME UNIQUE ASSEMBLY COMPLEXITIES AND LENGTHY TEST PROCEDURE
- (6) C-5A BRAKES ARE DISASSEMBLED IN A SPECIAL ROOM BECAUSE OF THE BERYLLIUM BRAKE



# LANDING GEAR GROUPINGS TO BE PROCESS CHARACTERIZED

<u>FAMILY NO</u>	<u>FAMILY CHARACTERISTICS</u>	<u>AIRCRAFT</u>
7	C-5 MLG STRUT ASSY	C-5
8	C-5 MLG BOGIE ASSY	C-5
9	C-5 NLG	C-5

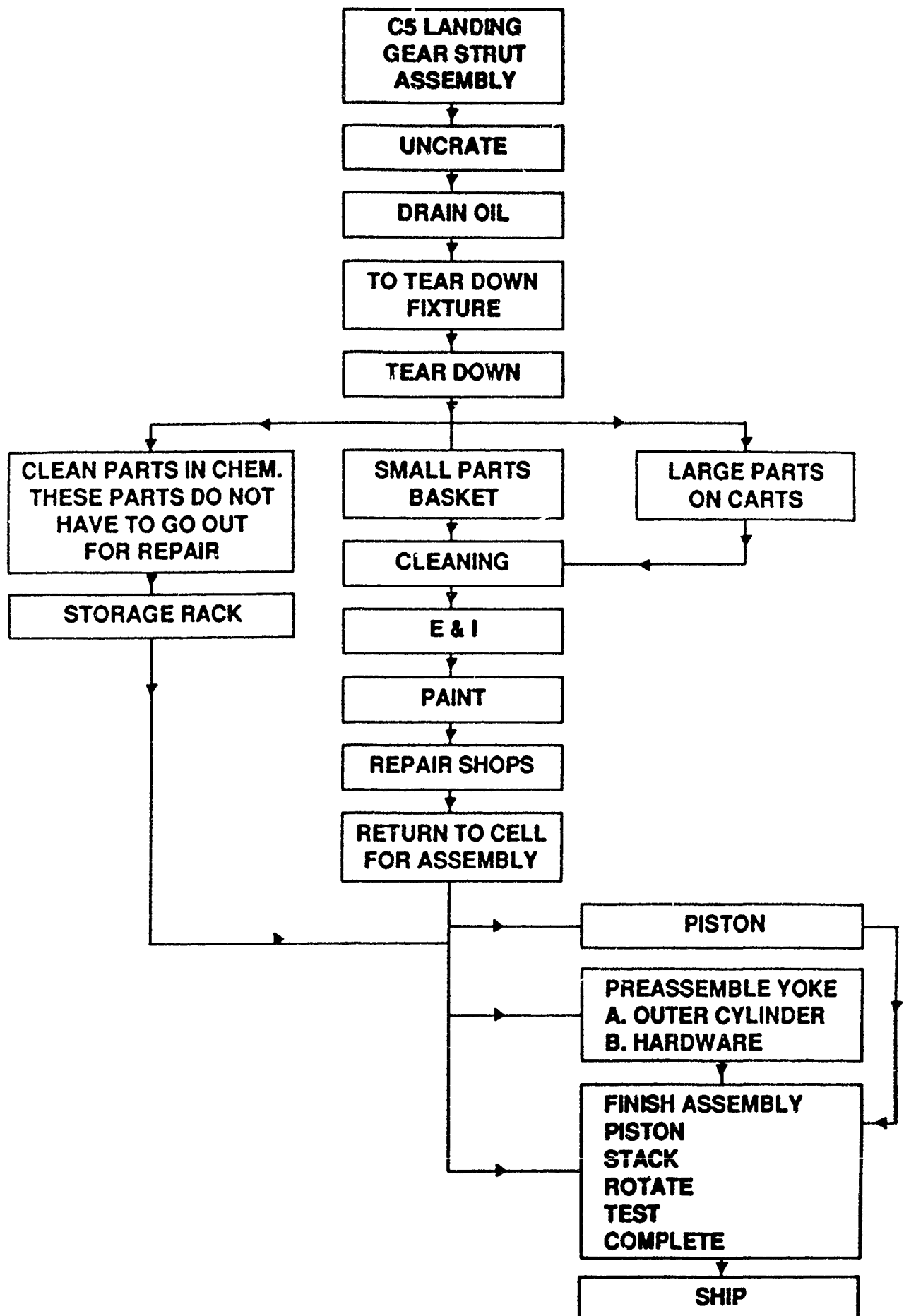
## LANDING GEAR GROUPING

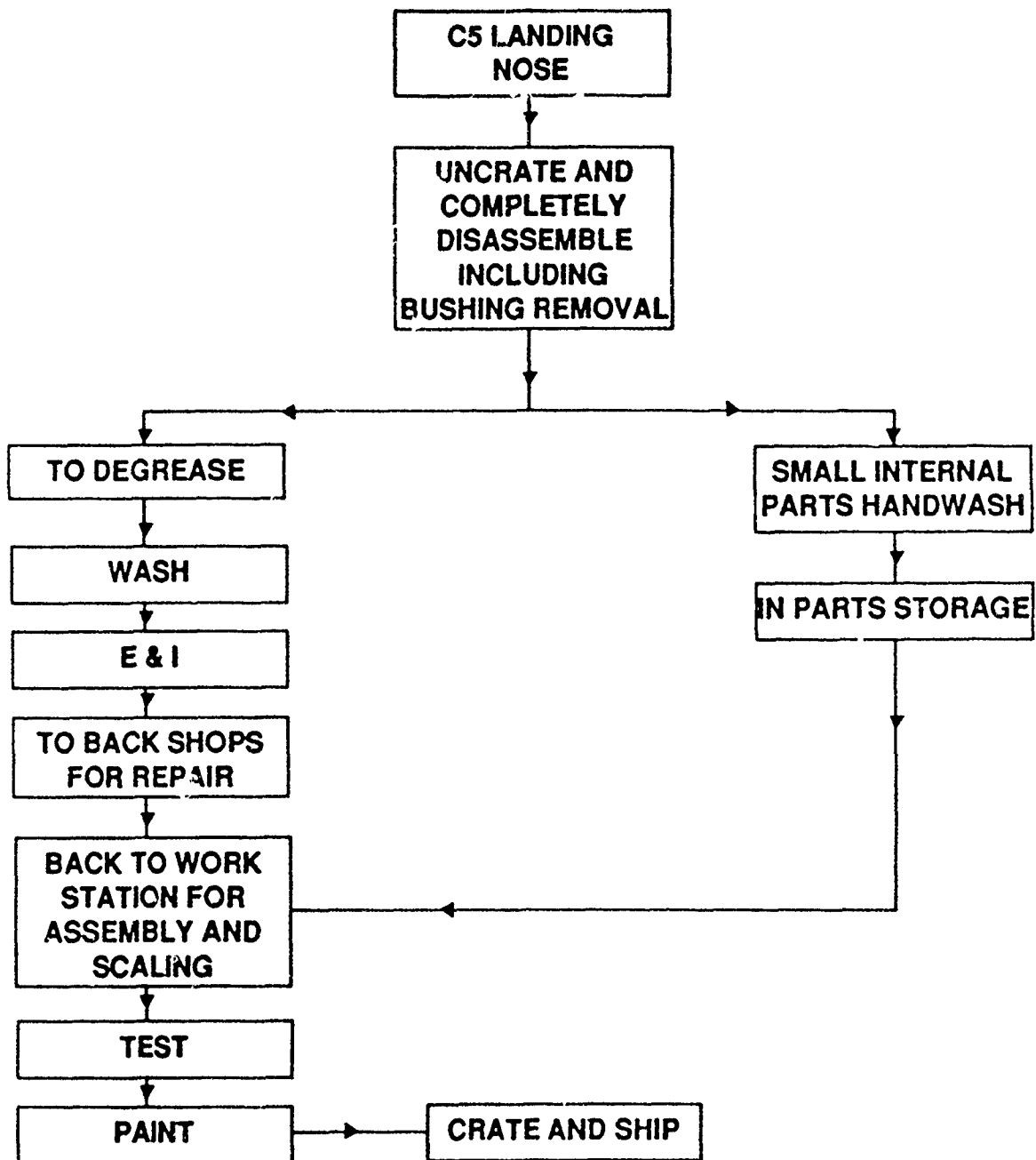
### NOTES:

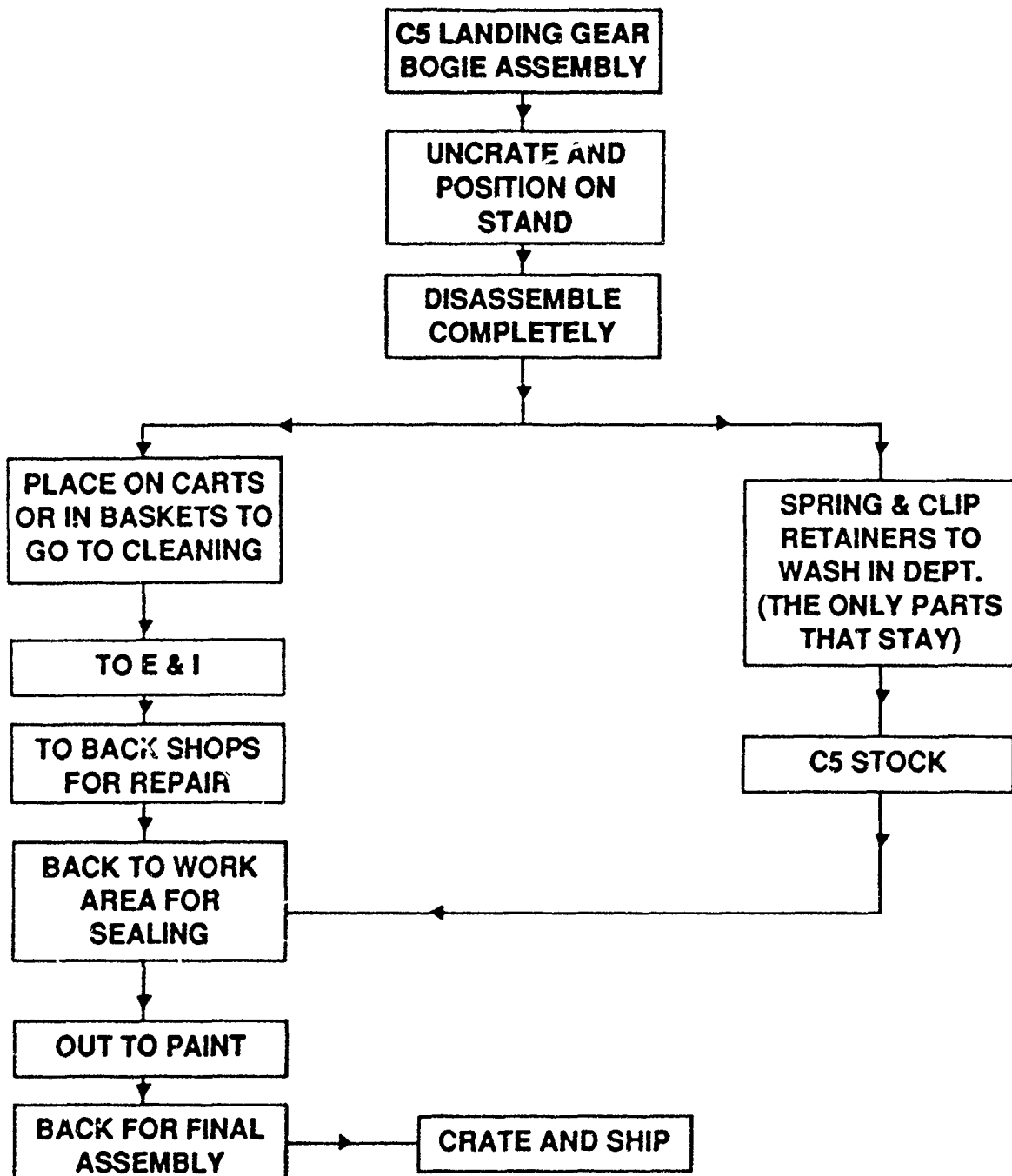
- (1) LANDING GEAR WAS BROKEN DOWN INTO 3 GROUPS
  - STEEL OUTER CYLINDER/STEEL INNER CYLINDER
  - ALUMINUM OUTER CYLINDER/STEEL INNER CYLINDER
  - C-5 M.L.G.
- (2) THE FIRST TWO GROUPS WERE SUBDIVIDED INTO SUBGROUPS BASED ON SIZE AND LIKENESS OF PROCESSES
- (3) THE GROUPS WERE VERIFIED BY COMPARING THE STANDARD HOURS USED BY MANPGP FOR THE ASSEMBLING PROCESS
- (4) FOREMAN IS DAVE BENNION

## PROPOSED WHEEL GROUPINGS

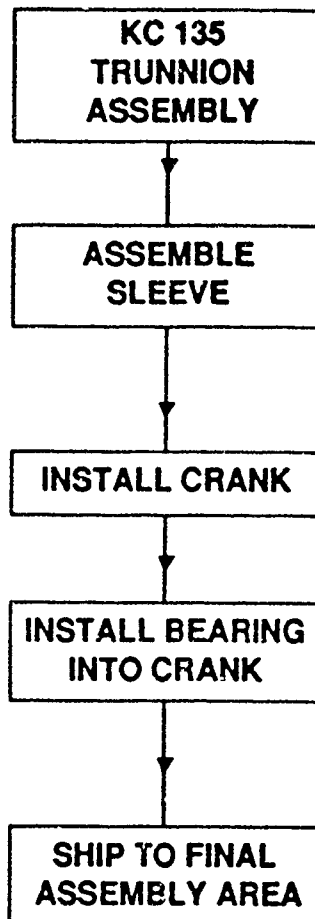
<u>FAMILY NO.</u>	<u>FAMILY CHARACTERISTICS</u>	<u>AIRCRAFT</u>
1	MAGNESIUM	KC-135N
2	ALUMINUM - LARGE	B-52M
3	ALUMINUM - MEDIUM	KC-135M
4	ALUMINUM - SMALL	T-38N
5	ALUMINUM - LARGE - SPECIAL BORES	C-5M
6	ALUMINUM - SMALL - SPECIAL BORES	C-5N



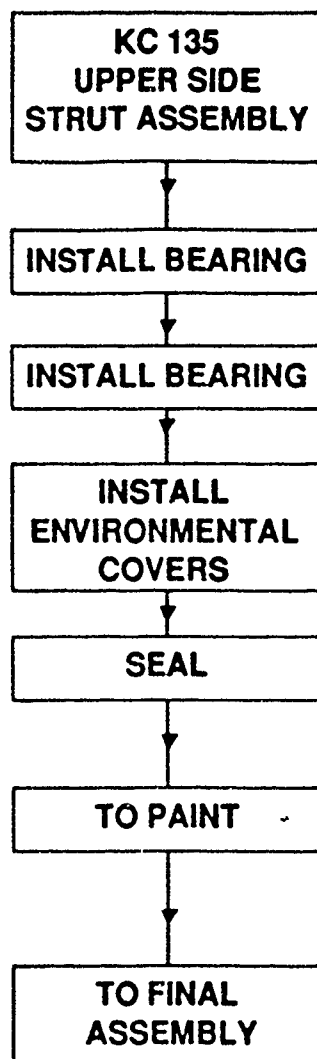




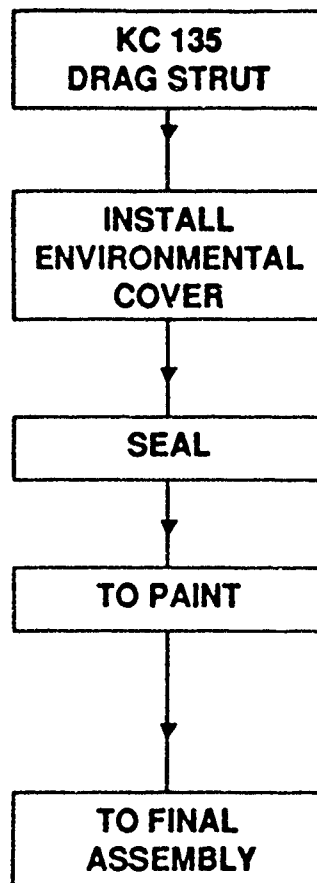




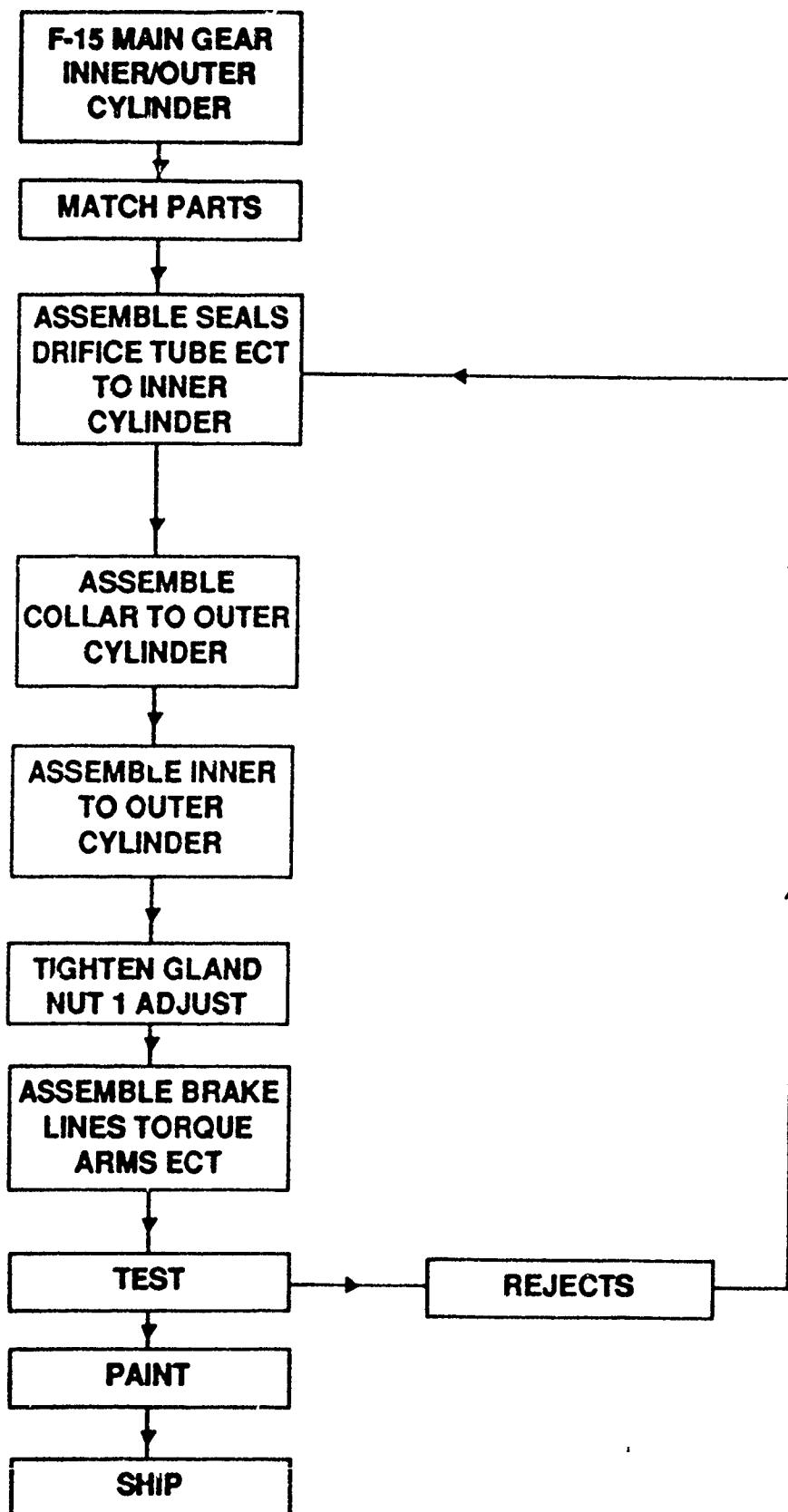
LSC-20124



LSC-20123

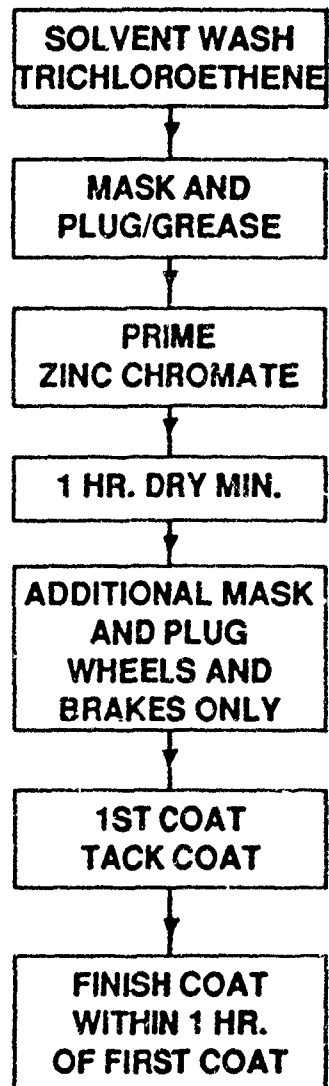


LSC-20122



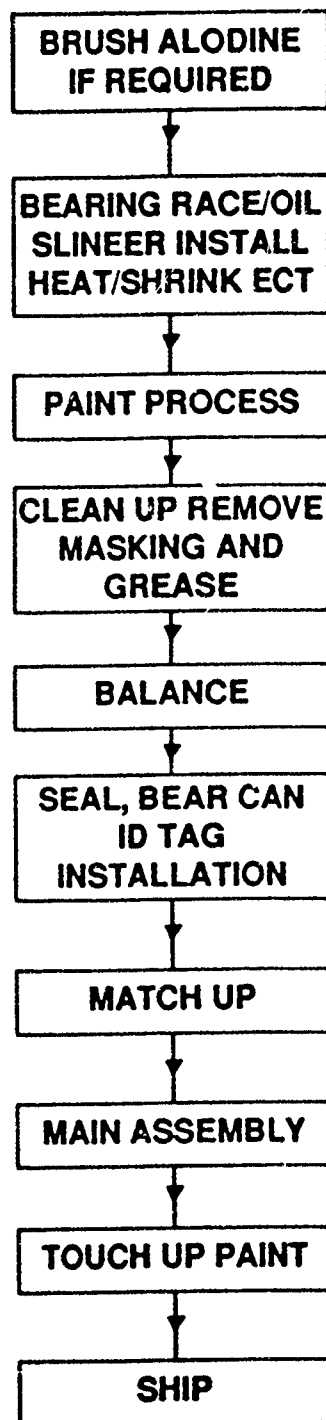
LSC-20127

## PAINT PROCESS FLOW CHART

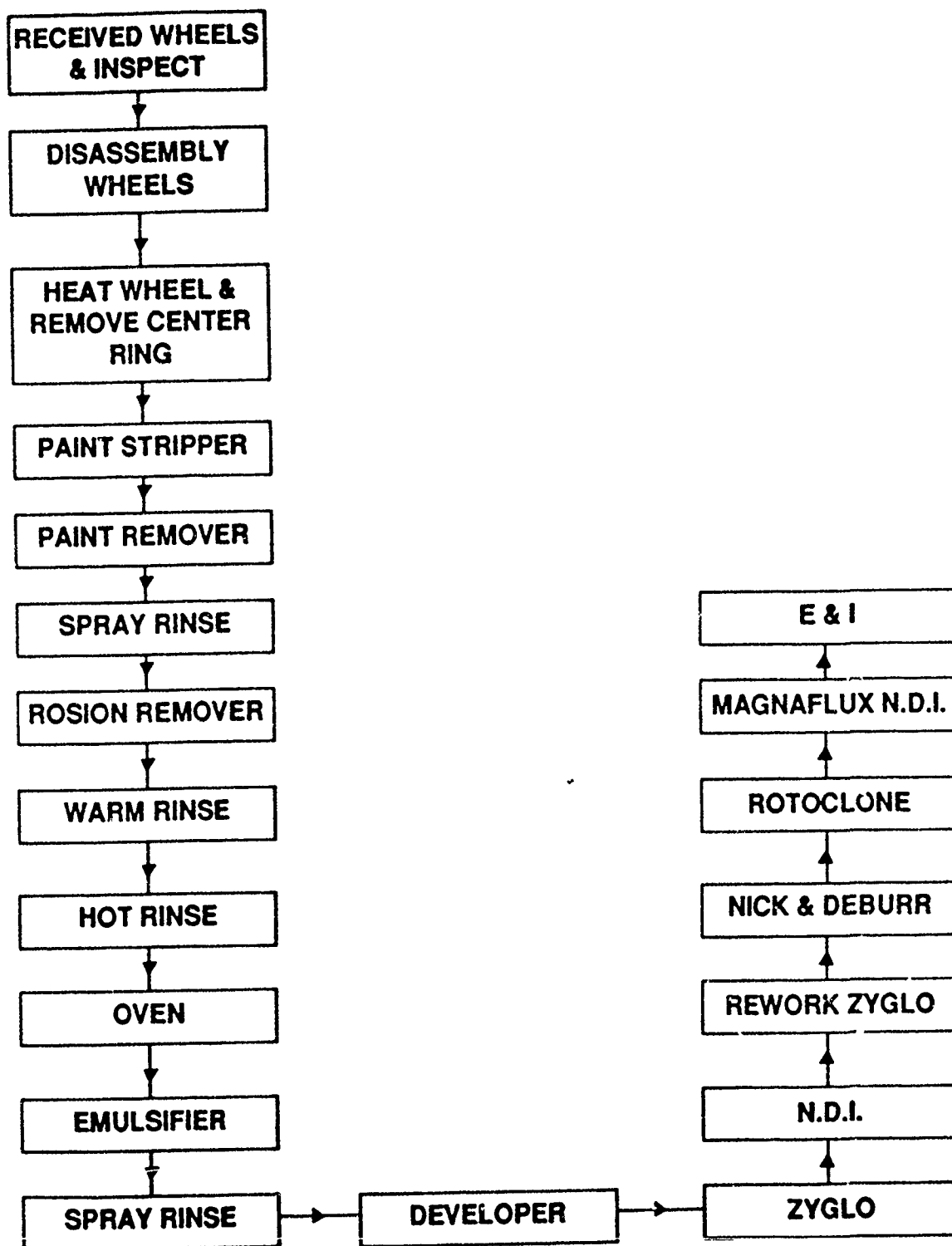


LSC-20128

## WHEEL ASSEMBLY FLOW CHART



LSC-20129



## BRAKE GROUPINGS TO BE PROCESS CHARACTERIZED

<u>FAMILY NO.</u>	<u>FAMILY CHARACTERISTICS</u>	<u>AIRCRAFT</u>	<u>STD. HRS. (MANPGP)</u>
1	MAGNESIUM HOUSING - STEEL BRAKE	"B-52" A-37, F-106 T-33, F-100	6.59 6.20
2	ALUMINUM HOUSING - STEEL BRAKE	"KC-135" A-7D, T-38 T-39, F-111 F-5, A-10 C-130, C-141 E-3A	6.69 4.78 6.65, 6.41 5.68, 4.38 6.63
3	ALUMINUM HOUSING - BERYLLIUM BRAKE	"C-5A"	13.41
4	ALUMINUM HOUSING - CARBON BRAKE	"C-5B" F-15	13.41
5	ALUMINUM HOUSING - CARBON BRAKE - SPECIAL ASSEMBLY CHARACTERISTICS	"F-16"	7.16
6	ALUMINUM HOUSING - STEEL BRAKE, SINGLE ROTOR	"C-130"	6.63



# LANDING GEAR GROUPINGS TO BE PROCESS CHARACTERIZED

<u>FAMILY NO.</u>	<u>FAMILY CHARACTERISTICS</u>	<u>AIRCRAFT</u>	<u>STD. HRS.</u> (MANPGP)
1	STEEL/STEEL	"F-15 MLG"	11.60
2	STEEL/STEEL	"C-101 <sup>4</sup> NLG"	8.03
3	STEEL/STEEL	"KC-135 MLG"	6.09
		F-4 NLG	5.44
		C-130 NLG	4.81
		C-130 MLG	3.29
		F-111 MLG	5.29
		A-7 MLG	3.35
		F-4 MLG	4.75
4	ALUM/STEEL	"F-15 NLG"	4.35
		F-16 NLG	3.84
		A-7 NLG	4.92
		T-38 MLG	3.40
		T-38 NLG	4.67
5	ALUM/STEEL	"KC-135 NLG"	6.66
		C-141 NLG	6.66
		A-10 MLG	7.75
		F-111 NLG	5.75
		A-10 NLG	7.75
6	ALUM/STEEL	B-52 MLG	11.20
		B-52 TIP	12.00

# LANDING GEAR GROUPINGS TO BE PROCESS CHARACTERIZED

<u>FAMILY NO</u>	<u>FAMILY CHARACTERISTICS</u>	<u>AIRCRAFT</u>
7	C-5 MLG STRUT ASSY	C-5
8	C-5 MLG BOGIE ASSY	C-5
9	C-5 NLG	C-5

## WHEEL GROUPINGS TO BE PROCESS CHARACTERIZED

<u>FAMILY NO.</u>	<u>FAMILY CHARACTERISTICS</u>	<u>AIRCRAFT</u>	<u>STD. HRS.</u> <u>(MANPGP)</u>
1	MAGNESIUM	KC-135N	2.67
2	ALUMINUM - LARGE	B-52M	2.47
3	ALUMINUM - MEDIUM (MAIN WHEELS)	"KC-135M" A-10M, C-5M C-130M, C-141M E-34M, F-4M F-5M, F-15M F-16M, F-100M F-106M, F-111M FB-111M	2.75
4	ALUMINUM - SMALL	"T-38N" A-10N, C-5N A-7N, C-130N E-3AN, F-4N	2.09

- NOTES: (1) FOREMAN IS BOB BURGER ALTERNATE IS CHARLES POWERS.  
 (2) ALL OF THE MAIN WHEELS ARE VERY SIMILAR IN SIZE AND PROCESS TIMES EXCEPT THE B-52 MAIN WHEEL  
 (3) ALL OF THE NOSE WHEELS ARE SIMILAR EXCEPT THE KC-135N WHICH IS MADE OF MAGNESIUM.

ALC. SASCAN. CNTL (008020P)

OCODEN 80/20 SORTED BY TOTAL HRS

3.12 FRIDAY, APRIL 7, 1988

## ALC SASCAN CNTL{008020P}

**LOGDEN 80/20 SORTED BY TOTAL HRS**

[illegible]









8 12 FRIDAY, APRIL 7, 1989

ALC SASCAN CNTL(008020P)

OGDEN 80/20 SORTED BY TOTAL HRS

N S N	P C N	O A L R S	O B S E R	P G W S	P G W P	P N A S	P N A P	P R A S	P R A P	P R B S	P R B P	P R C S	P R C P	P W S	P W P	L T	C U H
1620010054194	175821	21	5	81	0.0043					138	0.0004	178	0.0008			171.54	0.076877
1620010054191	176001	15	37	62	0.0043											178.99	0.077860
1620000071783	176011		14	117	0.0042											232.39	0.079007
1620012587842	183551			164	0.0042											187.55	0.079833
000F0004C	001008			235	0.0005			121	0.0009					38	0.0081	409.67	0.081854
000F0004E	001108													42	0.0038	143.81	0.082584
000F0004E	001108															87.71	0.083047
000F0004E	001108															428.73	0.085162
000F0004E	001108															183.50	0.086067
000F0004E	001108															3744.75	0.104543
000F0004E	001208							227	0.0001							3575.20	0.122182
000F0004E	001208															754.50	0.125804
000F0004E	001208															198.58	0.126884
000F0004E	001208															230.43	0.128021
000F0004E	001208															509.38	0.130534
000F0004E	001208															437.55	0.132693
000F0004E	001208															303.74	0.134191
000F0004E	001208															255.85	0.135453
000F0004E	001208															178.33	0.136328
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000F0004E	001208															568.86	0.139701
000F0004E	001208															538.23	0.142355
000F0004E	001208															665.98	0.145642
000F0004E	001208															58.47	0.145931
000F0004E	001208															128.90	0.146581
000F0004E	001208															408.80	0.148583
000F0004E	001208															1061.11	0.153818
000F0004E	001208															1508.12	0.161259
000F0004E	001208															868.85	0.166044
000F0004E	001208															878.01	0.170386
000F0004E	001208															1241.53	0.181115
000F0004E	001208															1728.83	0.190827
000F0004E	001208															1890.43	0.199167
000F0004E	001208															502.40	0.201841
000F0004E	001208															6248.32	0.232866
000F0004E	001208															803.51	0.236830
000F0004E	001208															215.45	0.237893
000F0004E	001208															88.07	0.238482
000F0004E	001208															988.18	0.243254
000F0004E	001208															537.88	0.245913
000F0004E	001208															416.38	0.247985
000F0004E	001208															2776.30	0.281857
000F0004E	001208															382.38	0.286861
000F0004E	001208															382.38	0.286861
000F0004E	001208															1854.54	0.275024
000F0004E	001208															490.78	0.277445
000F0004E	001208															213.25	0.278497
000F0004E	001208															336.28	0.280158





ALC.SASCAN.CNTL(008820P)

ODGEN 80/20 SORTED BY TOTAL HRS

8:12 FRIDAY, APRIL 7, 1981

N S	P C N	O P E R S	O B S E R	P G P S	P G P S	P G W S	P G W S	P M A S	P M A S	P R A S	P R A S	P R R S	P R R S	P R C C	P R C C	P W W S	P W W S	P W W S	P W W S	L T	U M
1620000271182	72572A	S 12	19	91	0.0025	133	0.0016	115	0.0017	134	0.0008	35	0.0074	50	0.8050	125	0.0007	328	0.7847	328	0.7847
16200004325851	72837A			49	0.0055	81	0.0047	88	0.0025	134	0.0008	31	0.0090	25	0.8027	71	0.0025	498	0.7892	498	0.7892
16200004649182	72896A		15	85	0.0028	28	0.0088	152	0.0010	39	0.0064	82	0.0020	95	0.8023	85	0.0018	741	0.7778	741	0.7778
1620000781082	74101A		7	141	0.0013	85	0.0026	104	0.0020	18	0.0158	82	0.0020	82	0.0040	85	0.0018	1050	0.7778	1050	0.7778
16200001877445	74101A			44	0.0068	21	0.0104	34	0.0066	13	0.0200	20	0.0148	34	0.0078	48	0.0054	1894	0.7778	1894	0.7778
16200002468005	74101A											17	0.0182	14	0.0157			272	0.7863	272	0.7863
16200002468005	74101A		2	37	0.0083	22	0.0087	17	0.0095	12	0.0230	26	0.0108	14	0.0157			341	0.7863	341	0.7863
1620000427877	74101A			30	0.0082	14	0.0134	47	0.0049	2	0.0494			18	0.0188	51	0.0047	3235	0.8013	3235	0.8013
1620000718658	74101A			192	0.0005	180	0.0008	223	0.0005	48	0.0054			216	0.0008			3785	0.8201	3785	0.8201
1620000748782	74101A			224	0.0016	84	0.0028	132	0.0012	78	0.0028			222	0.0017			312	0.8215	312	0.8215
1620000100858	74101A			34	0.0049	71	0.0035	242	0.0004	51	0.0051			304	0.0002	118	0.0009	340	0.8223	340	0.8223
16200001486488	74101A			107	0.0021	154	0.0011	148	0.0011	118	0.0010	57	0.0033	82	0.0030	143	0.0086	551	0.8250	551	0.8250
16200001781423	74101A			18	0.0121	58	0.0048	71	0.0033	44	0.0058	38	0.0065	24	0.0108	88	0.0027	348	0.8278	348	0.8278
1605000586752	74805A		2	110	0.0020	78	0.0031	126	0.0014	111	0.0011	88	0.0017	112	0.0020	14	0.0173	1475	0.8349	1475	0.8349
16200011827542	82717A			3	0.0403	4	0.0400	21	0.0058	1	0.0532	137	0.0004	87	0.0022	76	0.0022	1230	0.8410	1230	0.8410
16200011826267	82717A		5	186				215	0.0024	24	0.0027	88	0.0028	88	0.0038			344	0.8427	344	0.8427
16200002228223	84332A																	9803	0.8718	9803	0.8718
16500002183802LE	88828A																	248	0.8730	248	0.8730
																		178	0.8739	178	0.8739
																		0.8584	177130		











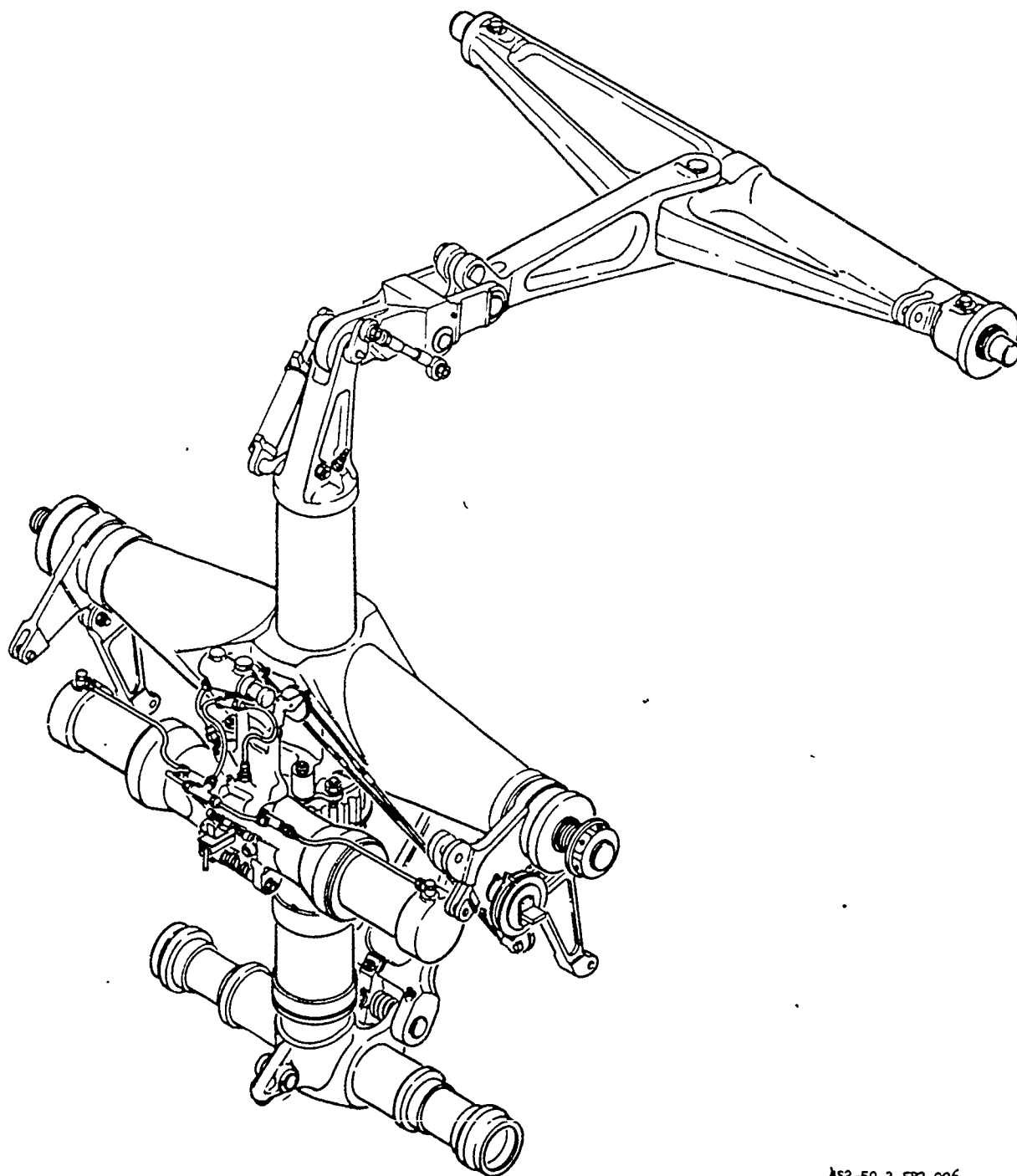


## ALC.SASCAN.CNTL(008020P)

OGDEN 80/20 SORTED BY TOTAL HRS

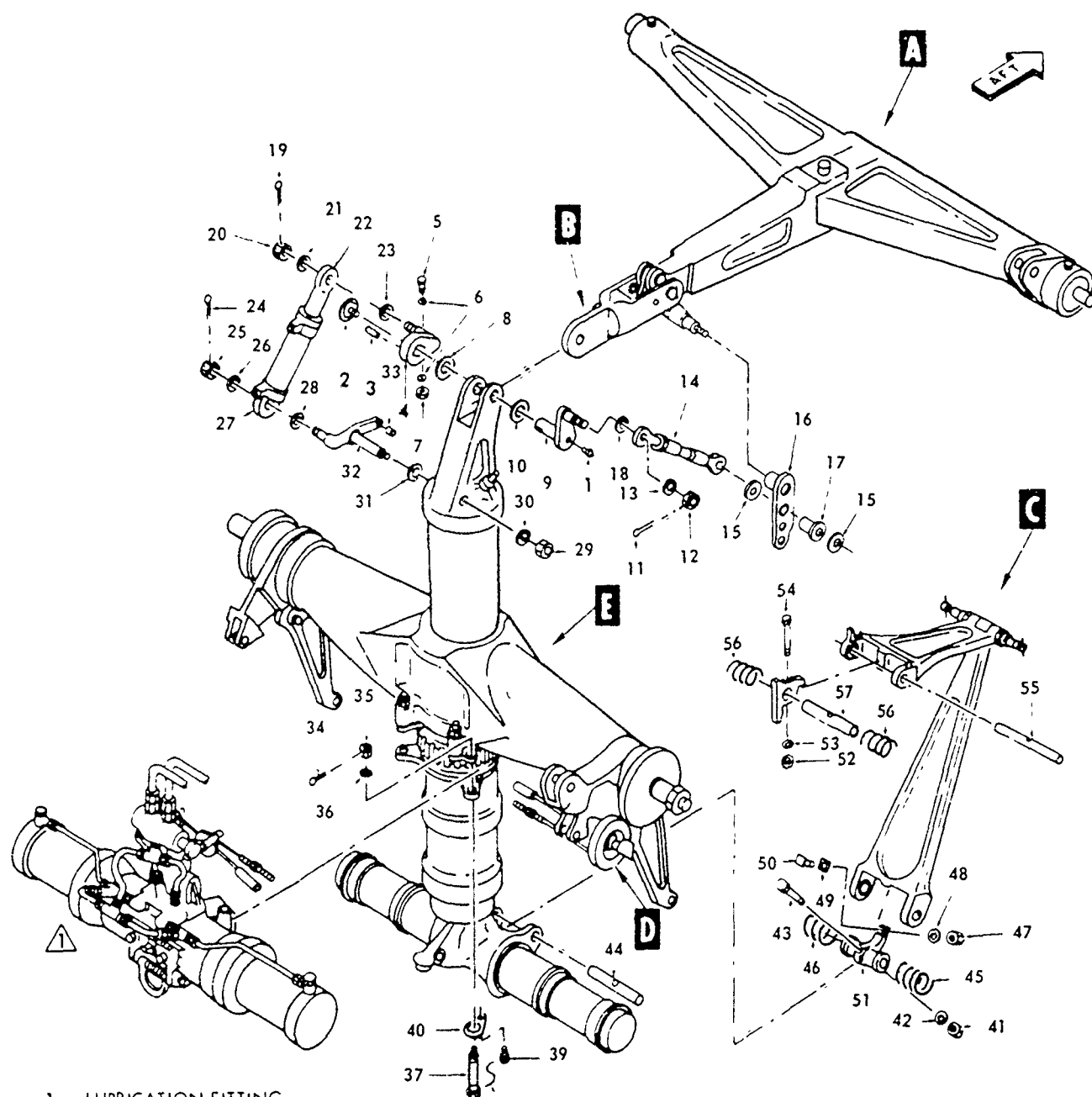
[illegible]

C-141 NLG



4S2-59-3-FB2-006

Figure 1-1. Nose Landing Gear Assembly



- |                        |                |                              |                 |
|------------------------|----------------|------------------------------|-----------------|
| 1. LUBRICATION FITTING | 18. WASHER     | 31. WASHER                   | 45. SPRING      |
| 2. NUT                 | 19. COTTER PIN | 32. CAM                      | 46. SPRING      |
| 3. LOCKPIN (2 PLACES)  | 20. NUT        | 33. BUSHING                  | 47. NUT         |
| 4. CAM                 | 21. WASHER     | 34. COTTER PIN (2 PLACES)    | 48. WASHER      |
| 5. BOLT                | 22. ROD END    | 35. NUT (2 PLACES)           | 49. SPACER      |
| 6. WASHER              | 23. WASHER     | 36. WASHER (2 PLACES)        | 50. BOLT        |
| 7. NUT                 | 24. COTTER PIN | 37. BOLT (2 PLACES)          | 51. SPRING LOCK |
| 8. WASHER              | 25. NUT        | 38. LOCKWIRE (2 PLACES)      | 52. NUT         |
| 9. CAM                 | 26. WASHER     | 39. SCREW (2 PLACES)         | 53. WASHER      |
| 10. WASHER             | 27. ROD END    | 40. LOCKING PLATE (2 PLACES) | 54. BOLT        |
| 11. COTTER PIN         | 28. WASHER     | 41. NUT                      | 55. PIN         |
| 12. NUT                | 29. NUT        | 42. WASHER                   | 56. SPRING      |
| 13. WASHER             | 30. WASHER     | 43. BOLT                     | 57. SPACER      |
| 14. ROD ASSEMBLY       |                | 44. PIN                      |                 |
| 15. HANDLE             |                |                              |                 |
| 16. BUSHING            |                |                              |                 |

452-59-3-FB3-024-1

Figure 2-1. Nose Landing Gear - Exploded View (Sheet 1 of 7)

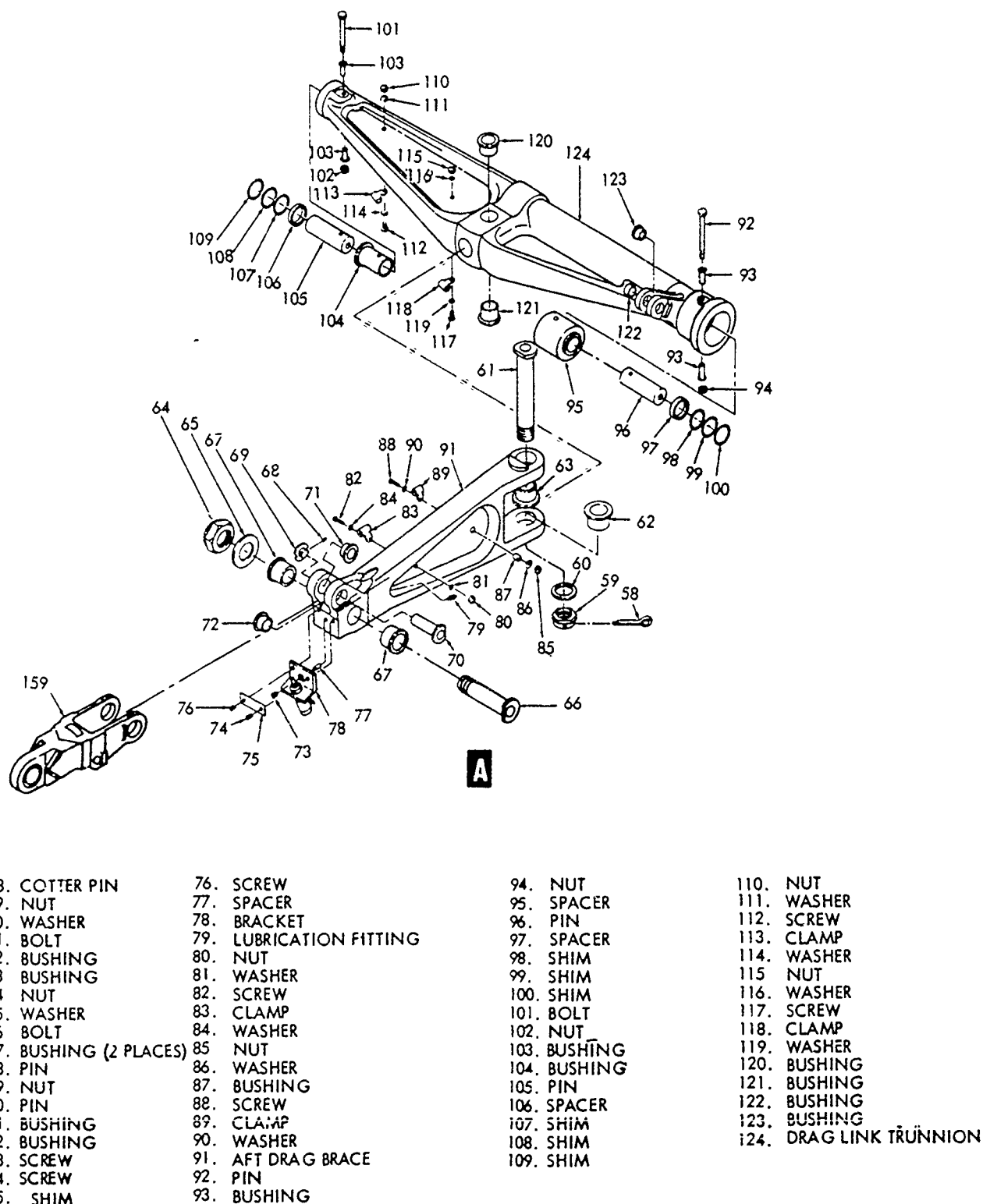


Figure 2-1. Nose Landing Gear - Exploded View (Sheet 2 of 7)

4S2-59-3-FBI-024-2

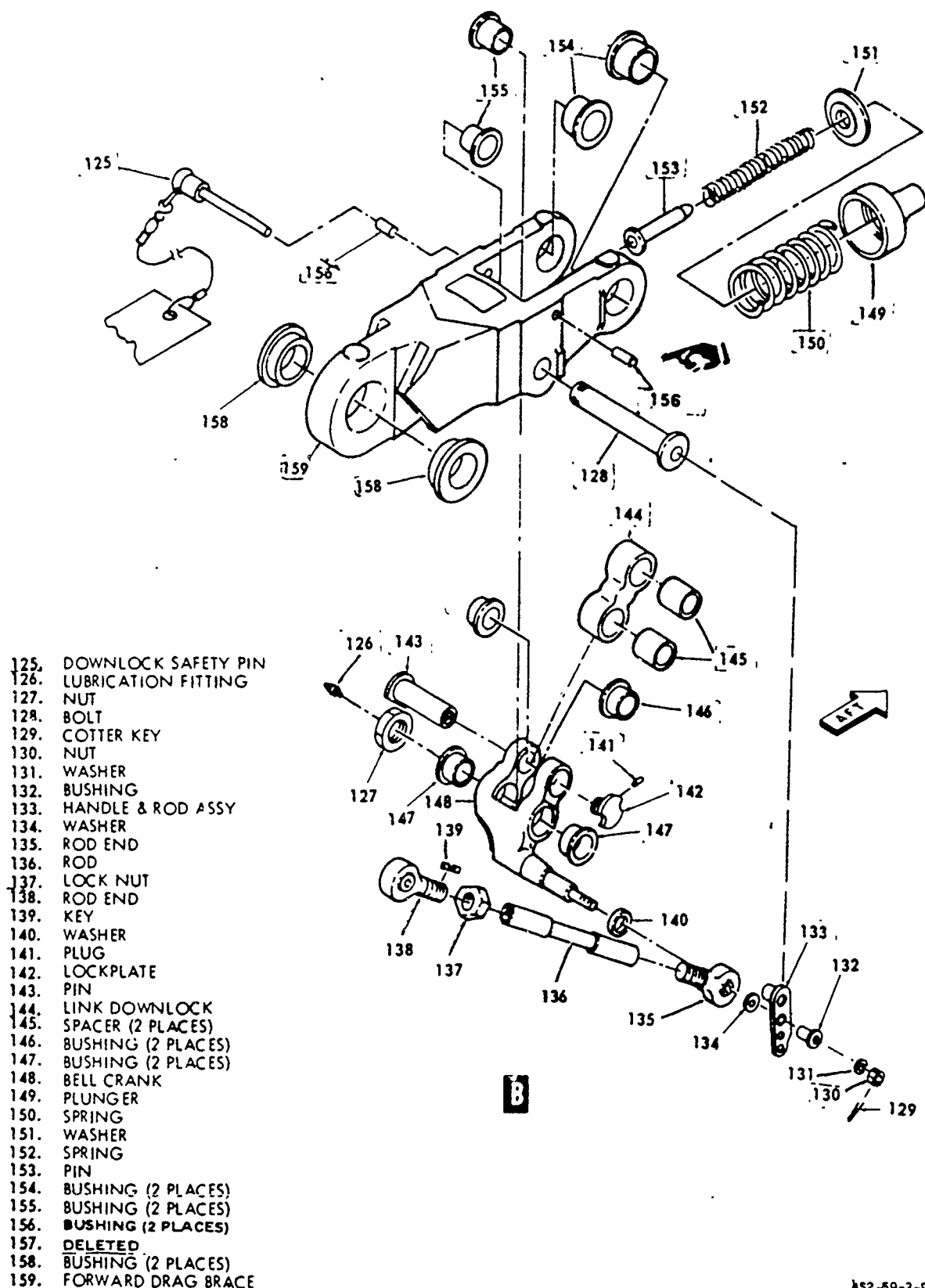
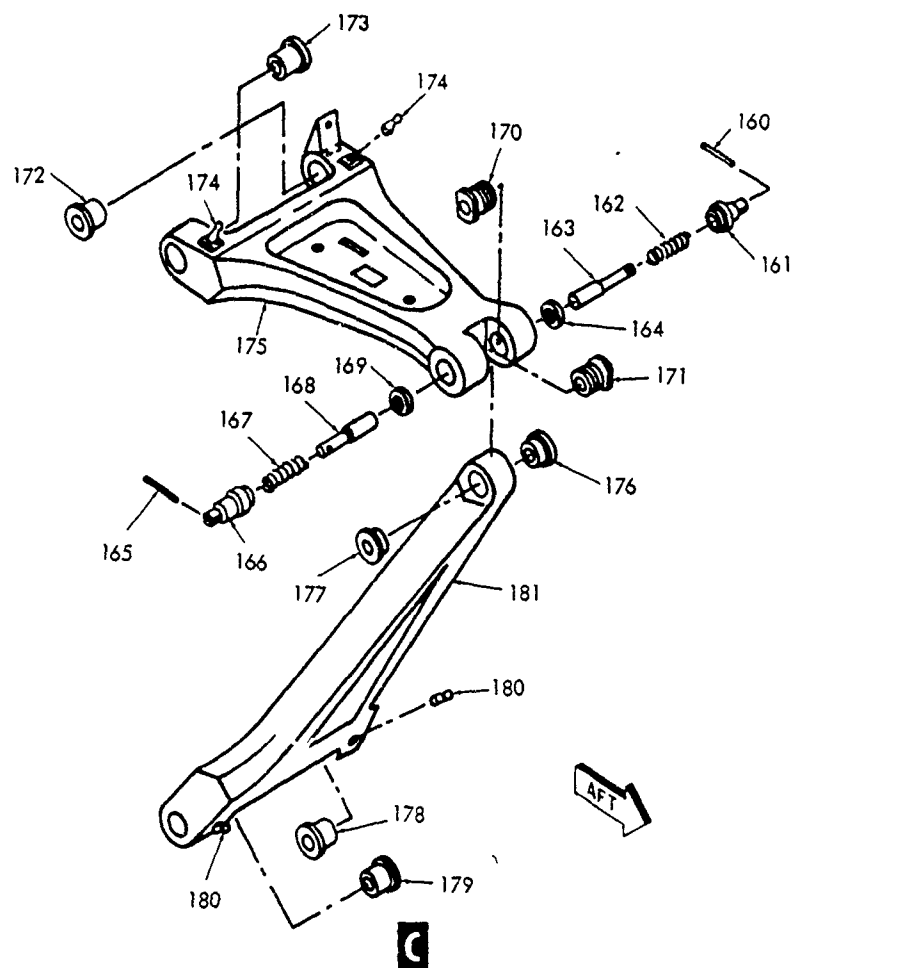


Figure 2-1. Nose Landing Gear - Exploded View (Sheet 3 of 7)



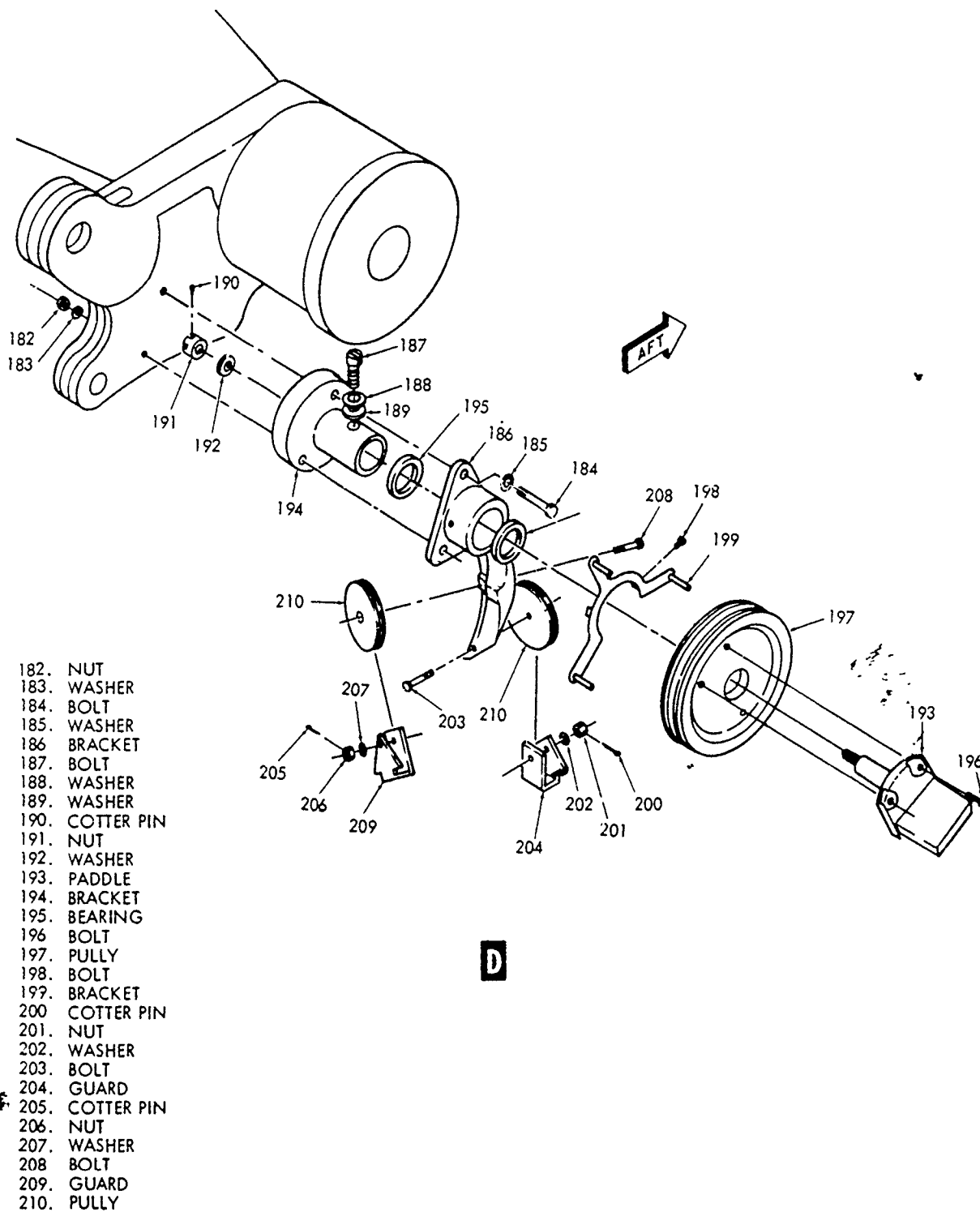
160. PIN	168. PIN	176. BUSHING
161. HOUSING	169. WASHER	177. BUSHING
162. SPRING	170. NUT	178. BUSHING
163. PIN	171. NUT	179. BUSHING
164. WASHER	172. BUSHING	180. LUBRICATION FITTING
165. PIN	173. BUSHING	181. LOWER TORQUE ARM
166. HOUSING	174. LUBRICATION FITTING	
167. SPRING	175. UPPER TORQUE ARM	

### NOTES

1. DISASSEMBLY AND OVERHAUL OF THE STEERING ACTUATOR ASSEMBLY IS COVERED IN T.O. 45A2-43-3.
2. THE TRUNNION IS INSTALLED ON THE STRUT WITH A TIGHT INTERFERENCE FIT. AND SHOULD NOT BE REMOVED UNLESS DAMAGED TO THE EXTENT THAT REPLACEMENT IS NECESSARY. (SEE PARAGRAPH 2-34)
3. THE AXLE IS INSTALLED WITH A VERY TIGHT INTERFERENCE FIT AND WILL REQUIRE A 100-TON HYDRAULIC PRESS FOR REMOVAL AND INSTALLATION.

452-59-3-FB1-024-4

Figure 2-1. Nose Landing Gear - Exploded View (Sheet 4 of 7)



4S2-59-3-FB2-024-5

Figure 2-1. Nose Landing Gear - Exploded View (Sheet 5 of 7)



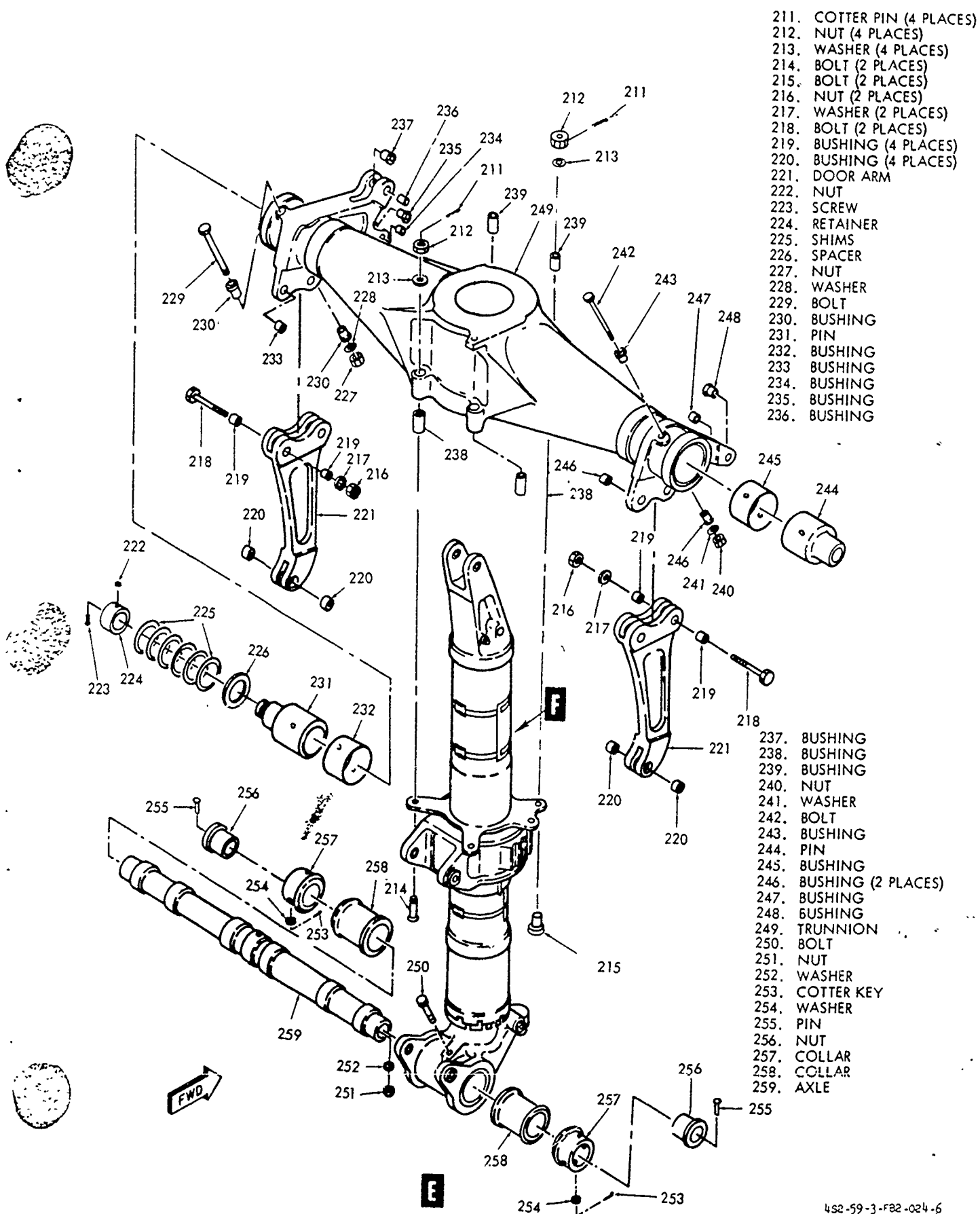
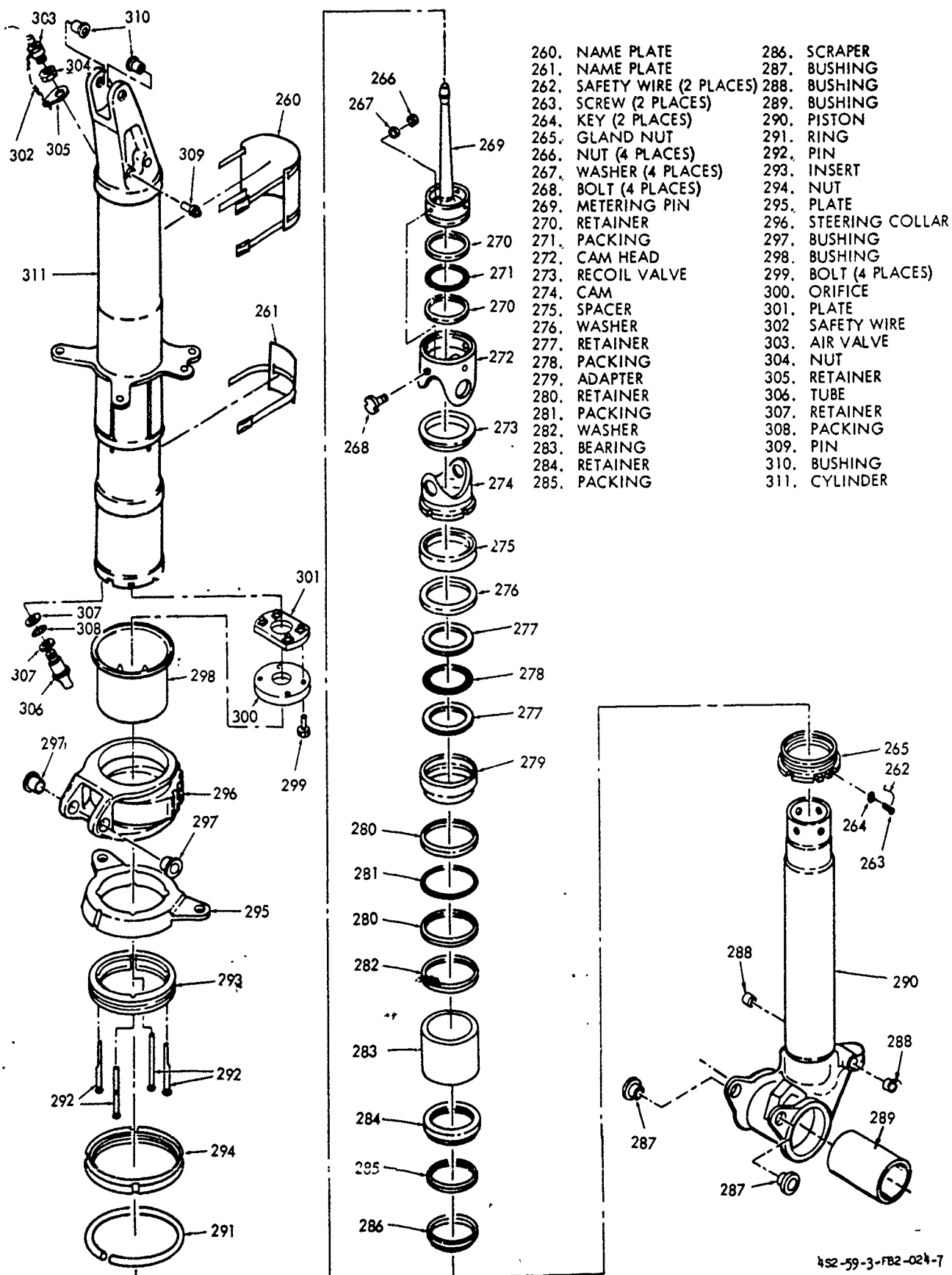


Figure 2-1. Nose Landing Gear - Exploded View (Sheet 6 of 7)

4S2-59-3-FB2-024-6

†. O. 4S2-59-3



4S2-59-3-FB2-024-7

Figure 2-1. Nose Landing Gear - Exploded View (Sheet 7 of 7)

# FAMILY 2

## CONTROL NUMBER LIST

LABO TECH	PLAN TECH	CONTROL NUMBER	JOP DESC	AIRCRAFT	DESCRIPTION	STOCK NUMBER	PART NUMBER	TECHORDER	G01 FLC DAY
JENS	RIGB	72895A	-J	C-5A MLG	BRAKE STATOR-BERYLLIUM	M 1630-00-464-9160LH	244-292	4B1-2-1063	30
JENS	RIGB	72896A	-G-J	C-5A MLG	BRAKE ROTOR-BERYLLIUM	M 1630-00-464-9162LH	244-293	4B1-2-1063	30
JENS	RIGB	72897A	-J	C-5A MLG	BRAKE END-PLATE-BERYLLIUM	1630-00-464-9165LH	244-294	4B1-2-1063	30
JENS	PRIC	72898A	-G-J	C-5A MLG	WHEEL	1630-00-286-1879	3-1258-2	4W3-4-413	17
JENS	PRIC	72899A	-G-J	C-5A MLG	WHEEL	M 1630-00-188-4084	3-1268-2	4W1-4-493	20
MART	SHEL	73041A	-G	B-52	BOOSTER 50 CAL	1005-00-300-5136	102450-2	11F46-16-3	8
MART	SHEL	73087A	-G	F-4E	CONTROL UNIT	1005-00-938-4572	53-790053-1	11F13-29-5-2	6
COOP	POLL	74506A	-J	C-141 MLG	DRAG BRACE	1620-00-932-2368	3F31001-114	4SA6-19-3	40
COOP	POLL	74516A	-G-J	C-141 MLG	DRAG BRACE	M 1620-00-179-1083	3F31004-123	4SA6-19-3	41
COOP	POLL	74518A		C-141 MLG	DRAG BRACE	1620-00-179-1087	3F31007-121	4SA6-19-3	47
COOP	POLL	74521A	-G	C-141 MLG	STRUT ASSY	M 1620-00-187-7445	366005-141	4S2-59-3	51
COOP	POLL	74524A	-G	C-141 MLG	BOGIE BEAM	M 1620-00-246-0005	3610010-105	4S1-73-3	48
COOP	POLL	74525A		C-141 MLG	ROOT PIN	5315-00-259-2512LE	3611512-107	4S1-73-3	25
COOP	POLL	74527A	-G	C-141 MLG	DRAG BRACE	M 1620-00-442-7877	3610009-113	4S1-73-3	54
COOP	POLL	74528A	-J	C-141 MLG	DRAG BRACE TRUNNION	1620-00-471-9659	3661096-117	4S2-59-3	34
COOP	POLL	74535A	-G-J	C-141 MLG	DRAG BRACE	1620-00-869-9889	3661098-105	4S2-59-3	35
COOP	POLL	74551A	-G-J	C-141 MLG	AFT SUPPORT SHAFT ASSY	1620-00-867-0810	3F31000-111	4SA6-19-3	40
COOP	POLL	74552A	-G-J	C-141 MLG	PIVOT PIN	1620-00-927-0298	3611112-107	4S1-73-3	31
COOP	POLL	74553A	-G-J	C-141 MLG	DRAG BRACE	1620-00-974-6793	3F31001-113	4SA6-19-3	35
DELE		74555A		A-7D MLG	AXLE BEAM ASSY	1620-00-052-3296	01/11/88	4A4-27-3	
TOLM	COOP	74561A	-G	A-7D MLG	STRUT ASSY	1620-00-135-7877	215-24030-31	4S1-71-3	
JENS	PRIC	74565A	-G-J	A-7D MLG	WHEEL	1630-00-075-2003	3-1193	4W3-7-1313	20
JENS	RIGB	74568A	-G-J	A-7D MLG	BRAKE ASSY	1630-410-0858MA	2-1215-2	4B1-2-1083	24
COOP	POLL	74571A	-G-J	C-141 MLG	TORQUE ARM ASSY	1620-00-931-7355	3660008-107	4S2-59-3	50
COOP	POLL	74575A	-J	C-141 MLG	DRAG BRACE ASSY	1620-00-929-9692	3661097-107	4S2-59-3	50
MART	SHEL	74579A		B-52	BOX END	1005-00-898-8672	571542-409	11F8-3-7-3	12
MART	SHEL	74588A		B-52	AMMO CAN	1005-00-623-6435	254771-518	11F8-3-8-2	13
DELE		74626A		C-5A MLG	INNER CYLINDER	1620-00-417-6249	01-11-88	4S1-93-3	
MONR	ANDE	74644A		C-5A MLG	SPLINED TUBE	1620-00-115-7393	4612432-101A	4S1-93-3	60
JENS	ANDE	74652A		C-5A	BALLSCREW	1620-00-148-6466	8155768	1663-2-00-3	45
MONR	ANDE	74653A	-G	C-5A MLG	ROLL PIN	1620-00-319-0461	4611437-107B	4S1-93-3	30
MONR	ANDE	74692A		C-5A MLG	BOGIE BEAM	M 1620-00-179-1425	46110114-101A	4S1-94-3	28
JENS	RIGB	74709A	-J	C-5A MLG	BRAKE HOUSING	1630-00-464-9167	266-36	4B1-2-1063	20
MART	SHEL	74802A		A-7	ENTRANCE UNIT	1005-00-043-1167	175F830	11W1-7-11-3	10
MART	SHEL	74803A			DRUM/FEED & STORAGE	2010-00-043-1175	MAUSBA	11W1-7-1-3	11
MART	SHEL	74805A	-G		GUN 20MM M61A1	M 1005-00-056-6753	7791641	11W1-12-4-33	3
MART	SHEL	74806A		XM18	POD SUU-16	1005-00-072-6612	11013605	11W1-31-2-2	35
MART	SHEL	74808A	-G	F-14/A-7	EXIT UNIT	1005-00-105-1083	175F846	11W1-7-103	7
MART	SHEL	74815A		C-130	CONTROL ASSY	1005-00-221-3126	175F857	11W1-34-3-1	6
MART	SHEL	74817A		C-130	FEEDER ASSY	1005-00-221-3325	175F869	11W1-7-9-2	7
MART	SHEL	74818A	-G	A-7D	CONTROL ASSY	1005-00-235-8299	188F683	11W1-7-9-2	6
MART	SHEL	74821A	-G	B-52	BOOSTER ASSY	1005-00-347-2304	2-00003-501	11F46-16-3	8
MART	SHEL	74823A	-G	A-7D	LOADER ASSY	1005-00-419-5074	176F415	11W1-7-1-103	5
MART	SHEL	74828A		F-4	AMMO HANDLING SYSTEM	1005-00-462-6523	175F938	11W1-7-11-3	45
MART	SHEL	74829A		F-4E	DRIVE ASSY	1005-00-848-2746	175F938	11W1-7-11-3	12
MART	SHEL	74831A		A-7	TRANSFER UNIT	1005-00-498-5359	175F632	11W1-7-7-1-103	12
MART	SHEL	74834A	-G	F-4	GUN M61 20MM AIR FORCE	1005-00-520-2620	7268702	11W1-12-3-22	20
MART	SHEL	74835A	-G		GUN A39A	1005-00-566-0045	8410951	11W1-12-3-22	7
MART	SHEL	74836A	-G	B-52	BOOSTER	1005-00-569-9715	2-00003-500	11F46-16-3	7
MART	SHEL	74837A		B-52	BOOSTER	1005-00-573-0197	39002-2	11W1-3-6-3	5

								FACTORED
PROD NBR	RCC	OPER NBR	TYP STD	SK	PAC	STAND HOURS	OCC FAC	STAND HOURS
-----								
74521A FAMILY 2 C-TAI NLG	MNPGR	00010	N	HS	5	6.57	1.00	6.67
		PP502	E	SS	5	.55	1.00	.55
		PP503	E	SS	5	.55	1.00	.55
		PP504	E	SS	5	1.09	1.00	1.09
		PP505	E	SS	5	.37	1.00	.37
		PP530	N	SS	5	2.26	1.00	2.26
								-----
								11.49
-----								
	MNPGW	P4530	E	DJ	5	1.46	1.00	1.46
		WC001	E	KI	5	1.71	1.00	1.71
		WD001	E	H3	5	5.43	1.00	5.43
		WE501	N	DI	5	.95	1.00	.95
		WE502	E	DI	5	.99	1.00	.99
		WE503	E	DI	5	1.74	1.00	1.74
		WE504	E	DI	5	.95	1.00	.95
		WE505	N	DI	5	.45	1.00	.45
		WE510	E	DI	5	.37	1.00	.37
		WE511	N	DI	5	.40	1.00	.40
		WE512	E	DI	5	.33	1.00	.33
		WE520	E	DI	5	.07	1.00	.07
		WE524	E	DI	5	.37	1.00	.37
		XNPGW	X	HS	5	2.97	1.00	2.97
								-----
								18.27
-----								
	MNPNA	NA501	E	DB	2	1.51	.82	1.23
		NA502	E	DB	2	.97	.67	.64
		NA503	E	DB	2	.74	.76	.71
		NA504	E	DB	2	.43	1.00	.43
		NA505	E	DB	2	.22	1.00	.22
		NA510	E	DB	2	.05	.05	.05
		NA511	E	DB	2	.64	.76	.61
		NA512	E	DB	2	.15	.96	.15
		XNPNA	X	DB	2	4.92	1.00	4.92
								-----
								8.91
-----								
	MNPRA	RA501	E	JA	1	12.94	.36	11.12
		RA502	E	JA	1	9.70	.89	8.63
		RA503	E	JA	1	2.12	.36	.76
		RA504	E	JA	1	26.67	.21	6.02
		RA510	E	JA	1	2.04	.29	.59
		RA511	E	JA	1	2.27	.96	2.17
		RA512	E	JA	1	2.79	.96	2.67
		RA520	E	JA	1	.73	1.00	.73
		RA524	E	JA	1	.34	1.00	.34
								-----
								33.08
-----								
	MNPRS	RS501	E	JA	3	15.78	.75	11.83
		RS502	N	JA	3	3.04	.50	2.52
		RS503	E	JA	3	4.04	.33	1.33

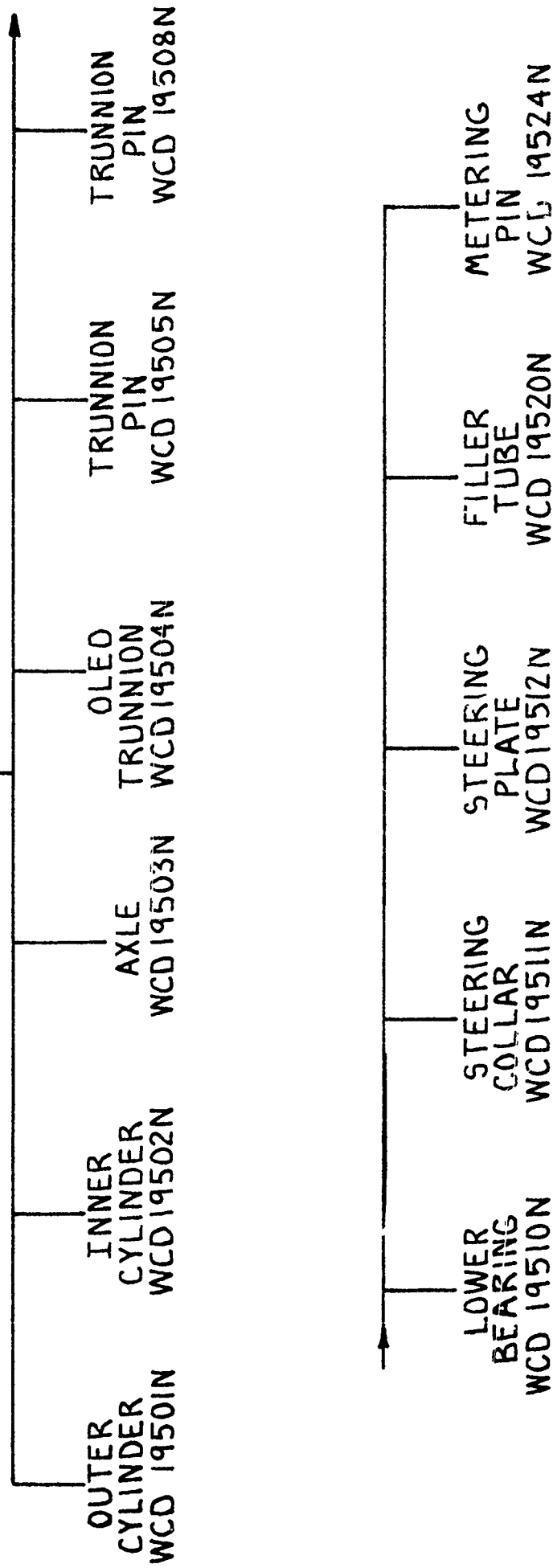
(64024-T1P001)

LABOR STD REVIEW 10 APR 69

4:38 PM

								FACTORED
PROD		OPER	TYP			STAND	OCC	STAND
NBR	RCC	NBR	STD	SK	FAC	HOURS	FAC	HOURS
-----	-----	-----	---	--	---	-----	-----	-----
74521A	MNPR	RC505	E	JA	3	3.19	.05	15
		RC506	E	JA	3	3.19	.05	15
		RC511	E	JA	3	2.49	.14	1.32
		RC512	E	JA	3	.97	.25	21
								-----
								17.51
★								
	MNPRC	RC509	E	UP	8	.54	1.00	64
		RC501	N	UP	8	3.59	1.00	3.59
		RC502	E	UP	8	3.22	.62	1.99
		RC503	E	UP	8	2.42	.93	2.25
		RC504	E	UP	8	1.14	.05	5
		RC505	N	UP	8	1.77	.38	67
		RC510	E	UP	8	.74	1.00	34
		RC511	N	UP	8	2.05	.90	1.84
		RC512	N	UP	8	1.43	.89	1.27
		XNPRC	X	UP	8	1.24	1.00	1.24
								-----
								13.88
★								
	MNPWW	WF501	N	WF	9	3.44	.25	86
		WF502	N	WF	9	4.31	.21	90
		WF504	N	WF	9	5.51	.07	38
		WF510	N	WF	9	1.55	.21	32
		XNPWW	X	WF	A	.06	1.00	6
								-----
								2.52
★								
								-----
								105.66

C-141 NOSE  
LANDING GEAR ASSEMBLY  
PCN 74521A  
WCD 19530N



16-May-2005

STL=STEEL  
AL=ALUMINUM  
MAG=MAGNESIUM  
TITA=TITANIUM  
SS=S STL  
SYN=SYNTHETIC  
LDB FAD

1 DAY FAD

[illegible]

74521A

97



C-141 NIG

BILL OF MATERIALS

74521A

ITEMS	ROUTED	ITEM CODE	LEVEL	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS	PER	OF	RATE	IF	SCOP	PART	MIC	REV	EFFECTIVITY	ITL	QND	PENDING	PENDING	PENDING	AFTO 2
1STL				13561015-101	13565004437240LE	98897	1. RING (RETAINING) (COLLAR)	11	EA														
1STL				13561015-101	13565007243825LE	98897	1. INSERT (LOCK-NUT)	11	EA														
1STL				13561015-101	13565007582266	98897	1. PIN (LOCKING) (COLLAR)	14	EA														
1STL				13561015-101	13565007214862	130C MFG	1. DECAL (INSTRUCTION)	11															
1STL				13561015-101	13565007289467	98747	1. KEY LOCK (GLAND NUT)	12	EA														
1STL				13561015-101	13565005598145	96906	1. SCREW, MACHINE	14	EA														
1STL				13561015-101	13565000077195	99999	1. PLATE (ANCHOR)	11	EA														
1STL				13561015-101	13565007296394	80205	1. BOLT, SHEAR	14	EA														
1STL				13561015-101	135650072040433	98897	1. PLATE (ORIFICE)	11	EA														
1STL				13561015-101	13565009474252	80205	1. BOLT (SHEAR)	11	EA														
1STL				13561015-101	13565009946968	80205	1. BOLT (SHEAR)	11	EA														
1STL				13561015-101	135650000514269	98897	1. WASHER (AXLE BOLT)	11	EA														
1STL				13561015-101	135650004492391	99999	1. NUT (LOCKING)	12	EA														
1STL				13561015-101	13565000073413LE	98747	1. NUT (GLAND)	11	EA														
1STL				13561015-101	135650012117612	72902	1. SCRAPER (RING)	11	EA														
1STL				13561015-101	135650005168223	96906	1. SCRAPER (RING)	11	EA														
1STL				13561015-101	N.S.L.		1. SCRAPER (RING)	11	EA														
1STL				13561015-101	135650000692205LE	98897	1. RETAINER (RING)	11	EA														
1STL				13561015-101	135650001257860	13002	1. BEARING (LOWER)	11	EA														
1STL				13561015-101	135650001257860	98897	1. BEARING (LOWER)	11	EA														
1STL				13561015-101	135650007118830LE	98897	1. WASHER (RETAINER)	12	EA														
1STL				13561015-101	1356500070289735LE	98897	1. ADAPTER (PACKING)	11	EA														
1STL				13561015-101	13565007023480LE	98897	1. SPACER	11	EA														
1STL				13561015-101	135650009086133	98897	1. CAM (CENTERING) (LOWER)	11	EA														
1STL				13561015-101	13565000590849	98897	1. KEY (CAM)	12	EA														
1STL				13561015-101	135650002334637	96906	1. RIVET (CAM)	12	EA														
1STL				13561015-101	13565010367740LE	98747	1. BOLT (PISTON HEAD CAM)	14	EA														
1STL				13561015-101	135650000514270	98897	1. WASHER (PISTON HEAD CAM)	14	EA														
1STL				13561015-101	135650086101786	96906	1. NUT (LOCKING)	15	EA														
1STL				13561015-101	N.S.L.		1. PISTON HEAD CAM	11															
1STL				13561015-101	13565009188532	98897	1. PISTON HEAD CAM	11	EA														
1STL				13561015-101	13565009086134	98897	1. VALVE (RECILL RING)	11	EA														
1STL				13561015-101	13565008676271	98897	1. PIN (METERING)	11	EA														

## 19530N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

PAGE 1 OF 1 PAGES

2. JOB ORDER NO. 74521A		3. QUANTITY		4. PRODUCTION SEC/RCC MNPBP		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER 3G60005-141				8. TECH DATA 4S-1-182 4S2-59-3			9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES C-141 NLG			11. STOCK NUMBER 1620001877445			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN: STRUT ASSEMBLY			74521A			
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES & HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER & T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O. & SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. "WARNING" MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	3G60005-141							
	010	MATCH-UP NLG STRUT ASSY *****ROUTED COMPONENTS***** NEW REWORKED NO SERVICEABLE 958 REWORK					001 MNPBP 002 06 003 SA03		
		PISTON -19502N OUTER 19501N							
		STR7COLLAR -19511N TRUNNION (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				19530N			
		B							
		C							
		D							

## 19530N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

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2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STRUT ASSEMBLY						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		19504N AXLE 19503N STR/PLATE							
		19512N TRUN/PIN 19505N LW/BEARING							
		19510N METERING/PIN 19524N FILLER/TUBE							
		19520N TRUN. PIN 19508N							
	490 *REQD*	PRE-TEST OF FILLER TUBE AREA *C/P MOVE					001 MNP GP 002 06 003 1L07		
	501 *REQD*	OK TO CLOSE AND/OR ASSEMBLE *C/P MOVE					001 MNP GP 002 06 003 SA03		
	503 *REQD*	REASSEMBLE IN REVERSE ORDER OF DISASSEMBLY IDENTIFY COMPONENT PARTS USED AND RECORD. NOUN 1 P/N 3 SERIAL# 1 NEW/REP					001 MNP GP 002 06 003 SA03		
		PISTON 13G61089-1153 1							
		CYL 13G61090-1173 1							
		STRG 13G61092-1113 1 GEAR 3 3 3							
		TRUN 33G61034-1093 1							
		AXLE 13G61032-1033 1 (CONTINUED)							

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	19530N
		B	D	

## 19530N WORK CONTROL DOCUMENT (MEDS)

DATE 89045

PAGE 01 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STRUT ASSEMBLY						
15. DISPATCH STATION	16. PERP RCC/CP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*C/P MOVE							
	505	REASSEMBLE *****NOTE***** *REQD* INSTALL BUSHING P/N 3G61007-101 WITH SEALANT PER MIL-S-81733, TYPE IS OPTIONAL.					001 MNP GP 002 06 003 SA03		
	506	SLOTS FOR PINS 3G61026-101 WILL BE FILLED WITH SEALANT PRIOR TO INSTALLATION OF PINS.							
	507	PRIOR TO INSTALLING LOCK RING P/N 3G61028-101 FILL GROOVE WITH SEALANT							
	508	INSTALL AXLE CHECK ROTATION OF STEERING COLLAR COLLAR SHOULD ROTATE FROM CENTER 60 DEGREES MIN IN BOTH DIRECTIONS.							
	509	ASSEMBLE AXLE AND BOLT TO PISTON BECAUSE OF LUG REWORK TWO BOLTS ARE AUTHORIZED P/N NAS1110-15 AND NAS 1110-16 SEE PARA. 2-62 D. PAGE 2-93							
	510	TORQUE ALL NUTS AND BOLTS TAW T.O. *C/P MOVE					001 MNP GP 002 06 003 TL07		
	512	PRESSURE TEST *C/P MOVE							
	515	MASK - PRIME - PAINT *C/P MOVE					001 MNP GP 002 09 003 WB03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19530N			
		B		D					

19530N

## WORK CONTROL DOCUMENT (MEDS)

1. DATE

89045

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
----------------	--------------	--------------------

10. MODEL/DESIGN/SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN STRUT ASSEMBLY	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
	516	TRUNNIONS REWORKED IAW DRWG 8241229 WILL HAVE A BLUE ONE INCH BAND PAINTED ON THE ENTIRE CIRCUMFERANCE 10 INCHES INBOARD FROM THE LEFT END			
		ANOTATE AFTO 95 TO SHOW COMPLIANCE WITH DRWG 8241229 LIMITED LIFE COMPONENT *C/P MOVE			
	518 *REQD*	AFTER COMPLETION OF ALL OTHER PAINTING, PAINT TURN LIMITS I.A.W. 452-59-3 PAGE 2-71. *C/P MOVE		001 MNP GP 002 09 003 WB03	
	520 *REQD*	DECALS *C/P MOVE		001 MNP GP 002 09 003 WB03	
	525 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *C/P MOVE		001 MNP GP 002 09 003 WB03	
	530 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNP GP 002 09 003 WB03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	19530N
		B	D	

## 19501N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

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2. JOB ORDER NO. 74521A		3. QUANTITY		4. PRODUCTION SEC/RCC MNP GP		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER 3G61090-119				8. TECH DATA 4S-1-182 4S2-59-3				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES C141 NOSE			11. STOCK NUMBER 1620004419763			12. OPTIONAL <b>74521A</b>			
13. SERIAL NUMBER			14. NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERF. RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		***** UNIT COST: \$15418.07 ***** GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 F.M.P.I. IAW MIL-STD-1949 P/O NO1561 ALODINE IAW MIL-C-5541 STRIP CHROME IAW MIL-STD-871 TEMPER ETCH IAW MIL-STD-867 SHOT PEEN IAW MIL-S-13165 CHROME PLATE IAW MIL-STD-1501 & P/O N61891 FPI IAW MIL-STD-6866 GRIND IAW MIL-STD-866 CAD PLATE IAW MIL-STD-870 GRIT BLAST IAW MIL-STD-1504 FLAME SPRAY IAW MIL-STD-869 BAKE IAW MIL-1-182 MAOI 74-12 VAC IVD ALUM PLATE IAW MIL-C-83488A ***300 M STEEL 280,00/300,000 PSI**							
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
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10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	3661090-119							
		DISASSEMBLE *C/P MOVE					001 MNP GW		
	*REQD*						002 02		
							003 LG02		
							005 X8745233		
							006 X8745235		
		CHEM CLEAN *C/P MOVE					001 MNP GW		
	*REQD*						002 03		
							003 SL01		
		BLAST CLEAN *C/P MOVE					001 MNP GW		
	*REQD*						002 03		
							003 BL01		
		BAKE 4 HRS AT 350-400F *C/P MOVE					001 MNP GW		
	*REQD*	DATE IN _____ TIME IN _____					002 03		
		DATE OUT _____ TIME OUT _____					003 BK03		
		*C/P MOVE				M	001 MNP NA		
	*REQD*						002 05		
							003 ML04		
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10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		E AND I INSPECTION					001 MNHGW		
		LOWER BORE I.D. 5.750/5.752					002 04		
		WEAR 5.753					003 EIO1		
		UPPER BORE I.D. 5.358/5.360							
		WEAR 5.361							
		UPPER CHAMBER I.D. 5.350/5.360							
		WEAR 5.370							
		DRAG ATTACH LUG ID 1.4375/1.4386							
		DRAG ATTACH LUG BUSHING I.D.							
		1.2465/1.2475 WEAR 1.2540							
		TRUNNION JOURNAL OD 6.134/6.136							
		COLLAR JOURNAL OD 6.2477/6.248							
		WEAR 6.2455							
		FILLER PLUG HOLE ID .938/.939							
		ACTUATOR LUG HOLE ID 1.060/1.061							
		WEAR 1.064							
		TORQUE LUG HOLES (4 EA) .626/.627							
		WEAR .631							
		STEERING LUG (2) EA .812/.813							
		WEAR .815							
		LINK PIN OD .305/.310							
		LINK PIN HOLE ID .469/.470							
		*C/P MOVE							
		* * * * * N O T E * * * * *							
		* A MINIMUM OF 2 FMPI OPERATIONS *							
		* MUST BE ACCOMPLISHED *							
		* * * * * * * * * * * * * * * * *							
26 ✓	055	VAPOR DEGREASE				*C/P MOVE		001 MNHRC	
								002 03	
								003 DG01	
26 ✓	060	STRIP CAD				*C/P MOVE		001 MNHRC	
								002 02	
								003 CS01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
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13. SERIAL NUMBER			14. NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26 ✓	065	STRIP RUST *C/P MOVE					001 MNPRC 002 02 003 CS02		
26 ✓	071	BLAST TO REMOVE METAL SPRAY FROM TRUNNION JOURNAL O.D. *C/P MOVE					001 MNPRC 002 01 003 BL02		
26B ✓	072	BAKE 4 HRS AT 350 TO 400F  DATE IN _____ TIME IN _____  DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****				M	001 MNPRC 002 06 003 ML04		
26 ✓	076	VAPOR DECREASE *C/P MOVE					001 MNPRC 002 03 003 DG01		
26 ✓	078	STRIP CHROME FROM TRUNNION JOURNALS THIS IS THE AREA ON THE UPPER SIDE OF FLANGE *C/P MOVE					001 MNPRC 002 02 003 SC02		
26 ✓	080	STRIP CHROME FROM COLLAR JOURNAL THIS IS THE AREA ON THE LOWER SIDE OF THE FLANGE. CAUTION: MAKE SURE THAT THE FILLER PLUG HOLE IS MASKED. DO NOT STRIP CHROME FROM FILLER HOLE PLUG *C/P MOVE					001 MNPRC 002 02 003 SC02		
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10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*C/P MOVE							
8	150	FIRST GRIND UPPER BORE FOR CHROME. GRIND TO CLEANUP MAX. ID 5.373 MAINTAIN .005 CONCENTRICITY WITH LOWER BORE RADIUS .160/.220 AT BOTTOM OF BORE FIG. 2-10. 32 RMS *C/P MOVE					001 MNPRB 002 01 003 GI01 005 X8745231		
8	160	FIRST GRIND LOWER BORE FOR CHROME. GRIND TO CLEANUP MAX. ID 5.765 .005 CONCENTRICITY WITH UPPER BORE RADIUS .770/.830 AT BOTTOM OF BORE FIGURE 2-10 32 RMS COMPLETED MAX THICKNESS OF CHROME .0075 *C/P MOVE					001 MNPRB 002 01 003 GI01 005 X8745231		
69	165	REMOVE LINK PIN *C/P MOVE					001 MNPRB 002 04 003 BE01		
69	170	EXTERNAL DEFECT REPAIR .010 DEEP BLEND TO PARENT METAL WITH 1 INCH RADIUS .020 DEEP IN THREADS MUST HAVE FOUR PERFECT THREADS OF EVERY 4 1/2 CONSECUTIVE THREADS FIG 2-10. *C/P MOVE					001 MNPRB 002 04 003 BE01		
69	180	POLISH O.D. AREA OF CYLINDER IAW PARA 2-34 T.O. 452-59-3 *C/P MOVE					001 MNPRB 002 04 003 BE01		
69	190	ATTACH LOG OVERSIZE REPAIR CLEANUP HOLES DO NOT EXCEED MIN. LOG WALL THICKNESS IN GRAPH FIG 2-10 (CONTINUED)					001 MNPRB 002 04 003 BE01		
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10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26 ✓	090	STRIP CHROME UPPER BORE +C/P MOVE					001 MNPRC 002 02 003 SC02		
26 ✓	100	STRIP CHROME LOWER BORE +C/P MOVE					001 MNPRC 002 02 003 SC02		
BG ✓	110	FIRST GRIND TRUNNION JOURNAL (FOR CHROME) GRIND TO CLEANUP, DO NOT EXCEED OD 6.121. MAINTAIN EXISTING RADIUS & CONCENTRICITY FIG 2-10 32 RMS *C/P MOVE					001 MNPRB 002 03 003 GG01 005 X8745198		
BG ✓	120	GRIND TRUNNION JOURNAL FOR FLAME SPRAY GRIND TO CLEANUP TO 6.090 MIN O.D. .190 TO .210 RADIUS AND BLEND SMOOTH TO GRIND SURFACE L.A.W FIG. 2-10 & FIG 2-13 32 RMS +C/P MOVE					001 MNPRB 002 03 003 GG01 005 X8745198		
BG ✓	130	FIRST GRIND COLLAR JOURNAL FOR CHROME GRIND TO CLEANUP, DO NOT EXCEED MIN DIAMETER OF O.D. 6.233 MAINTAIN EXISTING RADIUS AND CONCENTRICITIES FIGURE 2-10. 32 RMS +C/P MOVE					001 MNPRB 002 03 003 GG01 005 X8745198		
BG ✓	140	FIRST GRIND COLLAR JOURNAL FOR FLAME SPRAY GRIND TO CLEANUP WITHIN OD 6.217 INCREASE .120 RADIUS TO .135 AND BLEND SMOOTH TRANSITION TO GROUND SURFACE PARA 2-46 32 RMS DEFECT REMOVAL OF PITTING TO MAX OF 6.187 BY LOCAL POLISHING ONLY (CONTINUED)					001 MNPRB 002 03 003 GG01 005 X8745198		
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13. SERIAL NUMBER		14. NOUN OUTER CYLINDER					
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED			18. MECHANIC	19. "P"	20. "Q"
		125 RMS *C/P MOVE					
69 ✓	195	ACTUATOR LUG O/S REPAIR. CLEANUP LUG MIN ID 1.120 DONT EXCEED WALL THICKNESS IAW FIG 2-10 GRAPH 125 RMS *C/P MOVE				001 MNFRA 002 04 003 MH02	
69 ✓	200	TORQUE LUG (4 EA) OVERSIZE REPAIR MACHINE HOLES WITHIN ID .687/.707 DO NOT EXCEED MIN LUG WALL IN GRAPH FIG 2-10 125RMS *C/P MOVE				001 MNFRA 002 04 003 DR01 005 X8433681	
69 ✓	205	FILLER TUBE HOLE. MACHINE IAW 4S2-59-3 STAMP WITH LETTER "F" AND NUMBER OF REWORK. 1-2-3-4-5 125 RMS *C/P MOVE				001 MNFRA 002 04 003 BE01	
69 ✓	210	STEERING LUG (2 EA) OVERSIZE REPAIR MACHINE HOLES DO NOT EXCEED MIN LUG GRAPH WALL FIG 2-10 125RMS *C/P MOVE				001 MNFRA 002 04 003 DR01 005 X8433681	
69 ✓	215	LINK PIN HOLE OVERSIZE REPAIR CLEANUP HOLE. DO NOT EXCEED MIN WALL THICKNESS OF .100 FIG 2-10 DETAIL (D) 125 RMS *C/P MOVE				001 MNFRA 002 04 003 BE01	
69 ✓	220	STEERING FLANGE RADIUS REPAIR MACHINE TO REMOVE CORROSION IAW FIG 2-10 & 2-13 (THIS IS FOR TRUNNION SIDE ONLY) 125 RMS *C/P MOVE				001 MNFRA 002 04 003 BE01	
69 ✓	225	REMOVE PITTING ON STEERING FLANGE FACE BY THE TORQUE LUGS AND STEERING LUGS IAW GRAPH ON PAGE 2-49 FIG 2-10 125 RMS *C/P MOVE				001 MNFRA 002 04 003 BE01	
69 ✓	228	MACHINE VERTICAL SLOTS FOR KEYWAYS TO CLEAN UP CORROSION NOT TO EXCEED 6.010 MAINTAIN 0.1385 RADIUS				001 MNFRA 002 04 003 MH02 005 X8433681	
		***NOTE REMOVE ONLY MIN AMOUNT OF MATERIAL REQUIRED TO REMOVE CORROSION *C/P MOVE					
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10. MODEL DESIGN SERIES			11. STOCK NUMBER			12. OPTIONAL				
13. SERIAL NUMBER			14. NOUN OUTER CYLINDER							
15. DISPATCH STATION		16. PERF RCC/OP NO		17. WORK TO BE ACCOMPLISHED			18. MECHANIC		19. "P"	
69		230		RELOCATE & MACH NEW KEY SLOTS IAW FIG 2-10 & 2-11 IF DAMAGED WORN OR CORRODED BEYOND LIMITS IF GROUND FOR CHROME *C/P MOVE					001 MNPRA 002 04 003 MH02 005 X8633681	
69		235		REMOVE CORROSION IN RING GROOVE IAW T.O. *C/P MOVE					001 MNPRA 002 04 003 LE12	
				TIME OUT _____ DATE OUT _____ ***** NOTE *****			M		001 MNPRA 002 06 003 TE03	
				IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT ***** *C/P MOVE						
26B		290		BAKE 4 HRS AT 350F TO 400F WITHIN 8 HRS OF ETCH  DATE: _____ TIME IN: _____					001 MNPRA 002 02 003 AK01	
				DATE: _____ TIME OUT: _____ *C/P MOVE						
				*C/P MOVE ***** NOTE *****			M		001 MNPRA 002 06 003 ML04	
				IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****						
26		305		VAPOR DECREASE *C/P MOVE					001 MNPRA 002 03 003 DG01	
26		310		SHOT PEEN ALL SURFACES THAT HAS BEEN NICK AND BURRED INTENSITY OF .008/.012 A2 EXCEPT THREADS AND LUG (CONTINUED)					001 MNPRA 002 01 003 SP02	
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10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. P	20. Q	
		HOLES *C/P MOVE							
26 ✓	315	SHOT PEEN FILLER PLUG HOLE INTENSITY OF .008/.012 A2 *C/P MOVE						001 MNPRC 002 01 003 SP02	
26 ✓	320	SHOTPEEN TRUNNION JOURNAL INTENSITY OF .008/.012 A2 SHOT PEEN RADIUS ALSO *C/P MOVE						001 MNPRC 002 01 003 SP02	
26 ✓	330	SHOT PEEN FLANGE RADIUS BOTH SIDES INTENSITY OF .008/.012 A2 100 PERCENT SATURATION. THIS IS MANDATORY DURING OVERHAUL. STAMP LETTER "S" 1AW 452-59-3 *C/P MOVE						001 MNPRC 002 01 003 SP02	
26 ✓	335	SHOT PEEN STEERING FLANGE AREA THAT HAS BEEN REWORKED. INSTNSITY OF .008/.012 A2 *C/P MOVE						001 MNPRC 002 01 003 SP02	
26 ✓	340	SHOT PEEN COLLAR JOURNAL JAW MIL-S-13165 INTENSITY OF .008/.012 A2. SHOT PEEN RADIUS ALSO *C/P MOVE						001 MNPRC 002 01 003 SP02	
26 ✓	350	SHOT PEEN UPPER BORE INTENSITY OF .008/.012 A2 *C/P MOVE						001 MNPRC 002 01 003 SP02	
26 ✓	360	SHOT PEEN LOWER BORE INTENSITY OF .008/.012 A2 *C/P MOVE						001 MNPRC 002 01 003 SP02	
26 ✓	370	SHOT PEEN UPPER CHAMBER AREA INTENSITY OF .008/.012 A2 *C/P MOVE						001 MNPRC 002 01 003 SP02	
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26 ✓	373	PREPARE TRUNNION JOURNAL O.D. FOR CHROME PLATE. FIXTURE/MASK/ETC. *C/P MOVE MECHANIC SIGN OFF REQUIRED					001 MNPRC 002 02 003 BE01 005 X7929105		
26 ✓	377	PREPARE TRUNNION JOURNAL FOR CHROME PLATE, GRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 BL02		
26 ✓	380	CHROME PLATE TRUNNION JOURNAL SUFFICIENT TO GRIND O.D. BACK TO 6.134/6.136 TYPE II CLASS III DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED----- *C/P MOVE					001 MNPRC 002 02 003 CP01 005 X7929105 008 C0010		
26 ✓	383	PREPARE COLLAR JOURNAL OD FOR CHROME PLATE, FIXTURE/MASK/ETC. *C/P MOVE					001 MNPRC 002 02 003 BE01 005 X7929105		
26 ✓	387	PREPARE COLLAR JOURNAL FOR CHROME PLATE, GRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 BL02		
26 ✓	390	CHROME PLATE COLLAR JOURNAL SUFFICIENT TO GRIND O.D. BACK TO 6.247/6.248 TYPE II CLASS III DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED----- *C/P MOVE					001 MNPRC 002 02 003 CP01 005 X7929105 008 C0020		
26B ✓	395	BAKE 4HRS AT 3 400F DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26 ✓	397	PREPARE UPPER BORE ID FOR CHROME PLATE. FIXTURE/MASK/ETC. *C/P MOVE MECHANIC SIGN OFF REQUIRED					001 MNPRC 002 02 003 BE01 005 X7432858		
26 ✓	398	PREPARE UPPER BORE FOR CHROME PLATE GRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 BL02		
26 ✓	400	CHROME PLATE UPPER BORE SUFFICIENT TO GRIND I.D. BACK TO 5.358/5.360 TYPE II CLASS III DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED----- *C/P MOVE					001 MNPRC 002 02 003 CP01 005 X7432858 008 CI010		
26 ✓	403	PREPARE LOWER BORE ID FOR CHROME PLATE. FIXTURE/MASK/ETC. *C/P MOVE MECHANIC SIGN OFF REQUIRED					001 MNPRC 002 02 003 BE01 005 X7432858		
26 ✓	407	PREPARE LOWER BORE FOR CHROME PLATE GRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 BL02		
26 ✓	410	CHROME PLATE LOWER BORE SUFFICIENT TO GRIND I.D. BACK TO 5.750/5.752 TYPE II CLASS III DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED----- *C/P MOVE					001 MNPRC 002 02 003 CP01 005 X7432858 008 CI020		
26B ✓	420	BAKE 4 HRS AT 350F TO 400F WITHIN 4 HRS OF CHROME DATE: _____ TIME IN: _____ DATE: _____ TIME OUT: _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*C/P MOVE					001 MNPWW		
							002 08		
							003 DG02		
		JOURNAL TO BE SPRAYED					001 MNPWW		
		PRIOR TO FLAME SPRAY					002 08		
		*C/P MOVE					003 BL01		
		UNION JOURNAL .004/					001 MNPWW		
		.007 BOND COAT METCO 405. SPRAY WITH					002 08		
		METCOLOY #2 TO ALLOW GRINDING BACK					003 FS03		
		TO DIA OF 6.134/6.136 *C/P MOVE							
		COLLAR JOURNAL .004/.007					001 MNPWW		
		BOND COAT METCO 405. SPRAY WITH					002 08		
		METCOLOY #2 TO ALLOW GRINDING BACK					003 FS03		
		TO DIA OF 6.247/6.248							
		***NOTE: DO NOT FILL LOCK RING							
		GROOVES OR KEY SLOT WITH							
		FLAME SPRAY.							
		*C/P MOVE							
BG	470	FINISH GRIND TRUNNION JOURNAL AFTER					001 MNPWB		
		FLAME SPRAY. GRIND TO OD 6.134/6.136					002 03		
		32 RMS					003 GG01		
		RECORD WEAR DIM IF REWORK LIMITS ARE					005 X8745198		
		EXCEEDED							
		RECORD REASON & CAUSE FOR EXCEEDING							
		REWORK LIMITS							
		*C/P MOVE							
BG	480	FINISH GRIND COLLAR JOURNAL AFTER					001 MNPWB		
		FLAME SPRAY. GRIND TO OD 6.247/6.248					002 03		
		REMOVE FLAME SPRAY FROM GROOVE 32RMS					003 GG01		
		REIDENTIFY AFTER FLAME SPRAY IAW T/O					005 X8745198		
		PARA 2-46 SUBPARAGRAPH R							
		RECORD WEAR DIM IF REWORK LIMITS ARE							
		EXCEEDED							
		RECORD REASON & CAUSE FOR EXCEEDING							
		REWORK LIMITS							
		*C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A				19501N			
		B							
		C							
		D							

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
BG	490	FINISH GRIND TRUNNION JOURNAL AFTER CHROME PLATE FINISH DIA OD 8.1347 6.136. BLEND EXISTING RADIUS AND CORNERS. CHROME RUN OUT MAX IS 3/8 INCH FROM START OF RADIUS. 32RMS *C/P MOVE					001 MNPRB 002 03 003 GG01 005 X8745198		
BG	500	FINISH GRIND COLLAR JOURNAL AFTER CHROME PLATE FINISH DIA OD 6.247/6.248. BLEND EXISTING RADIUS AND CORNERS. CHROME RUN OUT MAX IS 3/8 INCH FROM START OF RADIUS. 32RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE					001 MNPRB 002 03 003 GG01 005 X8745198		
B	520	FINISH GRIND UPPER BORE. FINISH DIA ID 5.358/5.360 BLEND EXISTING RADIUS & CORNERS FIG 2-10 32 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE					001 MNPRB 002 01 003 GI01 005 X8745231		
B	530	FINISH GRIND LOWER BORE. FINISH DIA ID 5.750/5.752. BLEND EXISTING RADIUS AND CORNERS FIG 2-10 32RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE					001 MNPRB 002 01 003 GI01 005 X8745231		
26B	540	BAKE 4HRS AT 350-400F DATE IN _____ TIME IN _____ (CONTINUED)					001 MNPRC 002 02 003 BK01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED				
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.				
10. MODEL-DESIGN-SERIES				11. STOCK NUMBER		12. OPTIONAL						
13. SERIAL NUMBER				14. NOUN OUTER CYLINDER								
15. DISPATCH STATION		16. PERF RCC/OP NO		17. WORK TO BE ACCOMPLISHED			18. MECHANIC		19. "P"		20. "Q"	
				DATE OUT _____ TIME OUT _____ *C/P MOVE								
				***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****			M		001 MNRNA 002 06 003 ML04			
26		555		VAPOR DEGREASE *C/P MOVE					001 MNRRC 002 03 003 DC01			
				***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****			M		001 MNRNA 002 06 003 ZS01			
69		565		RELOCATE & MACH NEW KEYWAYS IAW FIG 2-10 & 2-11 *C/P MOVE					001 MNRRA 002 04 003 MH02 004 X833681			
				NEW KEYSLOTS *C/P MOVE			M		001 MNRRC 002 02 003 BP01			
26		568		PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE					001 MNRRC 002 01 003 BL02			
26		570		CAD PLATE CLASS II TYPE II 5.1 SQ FT AT 255-357 AMPS TIME OUT _____ DATE OUT _____ (CONTINUED)					001 MNRRC 002 03 003 CA02			
21. FINAL DESTINATION				22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN				
DISPATCH		FUNCTIONAL CODE		A		C		19501N				
				B		D						

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*****NOTE: STEERING COLLAR GROOVES SHOULD BE PLATED. *C/P MOVE							
26B ✓	580	BAKE 23 HRS AT 350F TO 400F WITHIN 4 HRS OF PLATING  DATE IN _____ TIME IN _____  DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
26 ✓	585	IRIDITE *C/P MOVE					001 MNPRC 002 02 003 IR01		
26 ✓	590	BLAST TO REMOVE CORROSION IN THE UPPER CHAMBER I.D. *C/P MOVE					001 MNPRC 002 01 003 BL02		
		*C/P MOVE *****NOTE***** M IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****					001 MNPRC 002 06 003 ML04		
26 ✓	603	VAC IVD ALUM PLATE CLASS 2 TYPE 11 NOTE: OPERATION 580 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION.					001 MNPRC 002 03 003 IVD1		
26 ✓	607	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE					001 MNPRC 002 03 003 TA01		
69 ✓	609	MACHINE DRAG ATTACH LOG BUSHING PRESS FIT .0025/.005 FINISH TO SIZE 1.2465/1.2475 FACE TO FACE 1.501/ (CONTINUED)					001 MNPRC 002 04 003 LE00		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19501N			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		1.505 125 RMS *C/P MOVE							
69 ✓	610	DRAG ATTACH LUG BUSHING INSTALLATION P/N 3G61005-101 TO 3G61603-115 USE MIL-S-81733, FINISH I.D. 1.2465/ 1.2475 125 RMS					001 MNPRA 002 04 003 BE01		
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS							
		*C/P MOVE P/N 3G61005-101 P/N 3G61603-115							
69 ✓	615	MACHINE ACTUATOR LUG BUSHING .001/ .002 PRESS FIT. ID FINISH SIZE 1.060/1.061 125 RMS *C/P MOVE					001 MNPRA 002 04 003 LE00		
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS							
		*C/P MOVE P/N 66C33001-71ST							
69 ✓	620	ACTUATOR LUG BUSHING INSTALLATION P/N 66C33001-71ST USE MIL-S-81733 BUSHING SHOULD NOT PROTRUDE FROM HOLE. FINISH I.D. 1.060/1.061 IAW					001 MNPRA 002 04 003 BE01		
		FIG 2-10 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS							
		*C/P MOVE P/N 66C33001-71ST							
69 ✓	625	MACHINE TORQUE LUG BUSHINGS .001/ .0015 PRESS FIT FINISH ID SIZE .626/.627 125 RMS *C/P MOVE					001 MNPRA 002 04 003 LE00		
69 ✓	630	TORQUE LUG 4 EA BUSHING INSTALLATION P/N 66C33001-8197 USE MIL-S-81733 RECORD WEAR DIM IF REWORK LIMITS ARE					001 MNPRA 002 04 003 BE01		
				(CONTINUED)					
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19501N			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE							
		P/N 66C33001-81ST							
69 ✓	635	TORQUE LUG FINISH I.D. .626/.627 125 RMS *C/P MOVE					001 MNRA 002 04 003 DR01 005 X833694		
69 ✓	640	MACHINE OR MFG 7530983-01 O/S TUBE IAW 452-59-3 OR STD 3G61089-101 *C/P MOVE P/N 7530983-01					001 MNRA 002 04 003 LE00		
69 ✓	645	O/S TUBE INSTALLATION *C/P MOVE					001 MNRA 002 04 003 BE01		
69 ✓	648	MACHINE STEERING LUG BUSHING .001/ .0015 PRESS FIT FINISH SIZE ID .812/.813. NOTE: KEEP DIM TO TOP TOLERANCE OF .813 IF POSSIBLE 125 RMS *C/P MOVE					001 MNRA 002 04 003 LE00		
69 ✓	650	STEERING LUG BUSHING INSTALLATION EA. P/N 66C33001-79ST USE MIL-S- 81733 RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 66C33001-79ST					001 MNRA 002 04 003 BE01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19501N			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
69 ✓	655	FINISH ID .812/.813 125 RMS KEEP DIM TO TOP TOLER. IF POSSIBLE *C/P MOVE					001 MNRRA 002 04 003 DR01 005 X8633694		
69 ✓	660	MACHINE LINK PIN P/N 3G61163-101 MACHINE TO OBTAIN .0003/.0010 PRESS FIT. IAW FIG. 2-10- MAX FLANGE WIDTH OF .040. USE MIL-S-81733 IAW FIG 2-10 125 RMS *C/P MOVE P/N 3G61163-101					001 MNRRA 002 04 003 LE00		
69 ✓	665	LINK PIN INSTALLATION *C/P MOVE					001 MNRRA 002 03 003 BE01		
	745	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 950 *C/P MOVE					001 MNRGP 002 06 003 MU01		
	750	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD*					001 MNRGP 002 06 003 MU01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19501N			
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2. JOB ORDER NO. 74521A		3. QUANTITY		4. PRODUCTION SEC/RCC MNP GP		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER 3G61089-111				8. TECH DATA 4S-1-182 4S2-59-3				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES C141 NOSE			11. STOCK NUMBER 1620004983226			12. OPTIONAL <b>74521A</b>			
13. SERIAL NUMBER			14. NOUN INNER CYLINDER						
15. DISPATCH STATION	16. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"
		***** UNIT COST: \$2129.00 ***** GOVERNING DIRECTIVES: AFLCR 66-51 MANDI 66-3 F.M.P.I. IAW MIL-STD-1949							
		P/O NO1561 ALODINE IAW MIL-C-5541 STPIP CHROME IAW MIL-STD-871 TEMPER ETCH IAW MIL-STD-867							
		SHOT PEEN IAW MIL-S-13165 CHROME PLATE IAW MIL-STD-1501 FPI IAW MIL-STD-6866 CAD PLATE IAW MIL-STD-870							
		VACUUM CAD IAW MIL-C-8837 BRUSH PLATE IAW MIL-STD-865 4S-1-182 FLAME SPRAY IAW MIL-STD-869							
		GRIND IAW MIL-STD-866 BAKE IAW 4S-1-182 MAOI 74-12 VAC IVD ALUM PLATE IAW MIL-C-83488A							
		***4340 STEEL 260,000/280,000 PSI*** ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE					23. DOCUMENT/BN		
DISPATCH	FUNCTIONAL CODE	A					19502N		
		B					90		



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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN INNER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	3661089-111							
		DISASSEMBLE *C/P MOVE					001 MNP GW		
	*REQD*						002 02		
							003 LG02		
							005 X8745233		
							006 X8745235		
		CHEM CLEAN *C/P MOVE					001 MNP GW		
	*REQD*						002 03		
							003 SL01		
		BLAST CLEAN *C/P MOVE					001 MNP GW		
	*REQD*						002 03		
							003 BL01		
		BAKE 4 HRS AT 350-400F					001 MNP GW		
	*REQD*	DATE IN _____ TIME IN _____					002 03		
		DATE OUT _____ TIME OUT _____					003 BK03		
		*C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19502N			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED		
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL				
13. SERIAL NUMBER			14. NOUN INNER CYLINDER							
15. DISPATCH STATION		16. PERF RCC/OP NO		17. WORK TO BE ACCOMPLISHED			18. MECHANIC		19. "P" "Q"	
		*REQD*		*C/P MOVE			M		001 MNHNA 002 05 003 ML04	
		*REQD*		E AND I INSPECTION INNER CYLINDER O.D. 4.995/4.997 WEAR 4.994 INNER CYLINDER UPPER END O.D. 4.559/4.563 AXLE ATTACH LUG I.D. 3.999/4.000 AXLE CROSS BOLT HOLE I.D. .625/.628 WEAR .634 NOTE: IF AXLE LUG IS NOT FLAME SPRAYED O/S CROSS BOLT HOLE ON OPERATION 080. IF AXLE LUG IS FLAME SPRAYED O/S CROSS BOLT HOLE ON OPERATION 355. TORQUE ARM ATTACH LUG 1.6875/1.6886 AXLE LUG WEB AREA MINIMUM WALL .030 PISTON SEAL AREA I.D. IF I.D. SEAL AREA DOES NOT EXCEED 4.258 AND CORROSION IS LESS THAN .002 DEEP GLASS BLAST AND ROUTE TO SHOT PEEN. TORQUE ARM ATTACH LUG BUSHING I.D. 1.4973/1.5001 WEAR 1.5006 TOW LUG 0.750/0.755 *C/P MOVE * * * * * N O T E * * * * * * A MINIMUM OF 2 FMPI OPERATIONS * * MUST BE ACCOMPLISHED * * * * * *					001 MNHGW 002 04 003 EI01	
26. 035				VAPOR DEGREASE *C/P MOVE					001 MNHRC 002 03 003 DG01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE			23. DOCUMENT/SN					
DISPATCH		FUNCTIONAL CODE		A			C		19502N	
				B			D			

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN INNER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26 ✓	037	STRIP CAD *C/P MOVE					001 MNPRL	002 02	
							003 CS01		
26 ✓	040	STRIP RUST *C/P MOVE					001 MNPRL	002 02	
							003 CS02		
69 ✓	045	NICK & BURR LOCAL REWORK LIMITS TO 5% OF INVOLVED AREA IAW T.O. *C/P MOVE					001 MNPRA	002 04	
							003 BE01		
69 ✓	050	TORQUE ARM ATTACH LUG OVERSIZE REPAIR STANDARD HOLE SIZE I.D. 1.6875/1.6886. OVERSIZE TO CLEANUP 125 RMS *C/P MOVE					001 MNPRA	002 04	
							003 BE01		
69 ✓	060	AXLE ATTACH LUG REPAIR (FLAME SPRAY) MACHINE I.D. 4.030/4.080. HOLE MAY BE RELOCATED .050 OFF CENTER TO MAINTAIN LUG WALL THICKNESS. (MIN .690) (WEB AREA MIN .030) 125 RMS *C/P MOVE					001 MNPRA	002 04	
							003 MH02	005 X833691	
69 ✓	070	AXLE ATTACH LUG REPAIR (BUSHING) MACHINE FOR MIN BUSHING WALL OF .040 NOT TO EXCEED LUG WALL OF .690 MIN AND WEB AREA MIN .030. RELOCATE .050 IF NECESSARY 125 RMS *C/P MOVE					001 MNPRA	002 04	
							003 MH02	005 X833691	
69 ✓	080	CROSS BOLT HOLE OVERSIZE (BUSHING REPAIR) MACHINE OVERSIZE TO CLEANUP I.D. .686/.707 125 RMS NOTE: THIS OPERATION WILL ONLY BE DONE IF AXLE LUG IS NOT GOING TO BE FLAME SPRAYED. IF AXLE LUG IS TO BE REWORKED THE CROSS BOLT LUG O/S (CONTINUED)					001 MNPRA	002 04	
							003 MV03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN INNER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. P	20. Q	
		WILL BE DONE ON OPERATION 355. *C/P MOVE							
69 ✓	090	TOW LUG OVERSIZE REPAIR REAM OVERSIZE TO CLEANUP IAW T.O. 125 RMS *C/P MOVE					001 MNFRA 002 04 003 BE01		
26 ✓	095	VAPOR DEGREASE *C/P MOVE					001 MNFRC 002 03 003 DG01		
26 ✓	100	STRIP CHROME PISTON O.D. *C/P MOVE					001 MNFRC 002 02 003 SC02		
26 ✓	104	STRIP CHROME PISTON UPPER END O.D. *C/P MOVE					001 MNFRC 002 02 003 SC02		
26 ✓	108	STRIP CHROME METERING PIN I.D. SEAL AREA. *C/P MOVE					001 MNFRC 002 02 003 SC02		
8 ✓	110	FIRST GRIND PISTON O.D. FOR CHROME MINIMUM O.D. 4.980 32 RMS *C/P MOVE					001 MNFRC 002 03 003 GE06		
8 J	120	FIRST GRIND PISTON UPPER END O.D. FOR CHROME MINIMUM O.D. 4.547 32 RMS *C/P MOVE					001 MNFRC 002 03 003 GE06		
8 J	125	POLISH METERING PIN I.D. SEAL AREA NOT TO EXCEED 4.258 - IF CORROSION IS LESS THAN .002 DEEP SEND TO GLASS BLAST AND SHOT PEEN - IF CORROSION EXCEEDS .002 - ROOT TO OPER. #130 *C/P MOVE					001 MNFRC 002 01 003 BE01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19502N			
		B		D					

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL/DESIGN/SERIES				11. STOCK NUMBER				12. OPTIONAL	
13. SERIAL NUMBER				14. NOUN INNER CYLINDER					
15. DISPATCH STATION		16. PERF RCC/OP NO.		17. WORK TO BE ACCOMPLISHED				18. MECHANIC	
8		130		FIRST GRIND METERING PIN I.D. SEAL AREA GRIND TO CLEAR MAX I.D. 4.267 32 RMS *C/P MOVE				001 MNP RB 002 01 003 G101 005 X8745255	
				DATE OUT: ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT ***** *C/P MOVE				M 001 MNP NA 002 06 003 TE03	
23B		150		BAKE 4 HRS AT 350F TO 400F WITHIN 8 HRS OF ETCH DATE: TIME IN: DATE: TIME OUT: *C/P MOVE				001 MNP RC 002 02 003 BK01	
				***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT ***** *C/P MOVE				M 001 MNP NA 002 06 003 ML04	
26		163		VAPOR DECREASE *C/P MOVE				001 MNP RC 002 03 003 DG01	
23		165		GLASS BLAST PISTON SEAL AREA I.D. *C/P MOVE				001 MNP RC 002 01 003 BL03	
26		170		SHOT PEEN G.D. INTENSITY OF .010/.012 A2 *C/P MOVE				001 MNP RC 002 01 003 SP02	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN					
DISPATCH		FUNCTIONAL CODE		A		C		19502N	
				B		D		95	

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN INNER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26 ✓	180	SHOT PEEN PISTON UPPER END O.D. INTENSITY OF .010/.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26 ✓	190	SHOT PEEN METERING PIN I.D. SEAL AREA INTENSITY OF .010/.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26 ✓	200	SHOT PEEN AXLE ATTACH LUG INSIDE INTENSITY OF .010/.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26 ✓	215	SHOT PEEN ALL SURFACES THAT HAVE BEEN NICK AND BURRED .010/.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26 ✓	218	PREPARE FOR CHROME PLATE OF PISTON (LONG AREA O.D.) MASK/FIXTURE/ETC. *C/P MOVE MECHANIC SIGN OFF REQUIRED					001 MNPRC 002 02 003 BE01		
26 ✓	220	CHROME PLATE PISTON (LONG AREA O.D.) TO ALLOW GRINDING BACK TO O.D. 4.995/4.997 CLASS III TYPE II. TIME OUT _____ DATE OUT _____ MECHANIC SIGN OFF REQUIRED *C/P MOVE					001 MNPRC 002 02 003 CP01 008 CC010		
26B ✓	225	BAKE 4 HRS AT 350-400F WITHIN 4 HRS OF CHROME PLATE DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
26 ✓	228	PREPARE FOR CHROME PLATE OF PISTON (UPPER SHORT AREA O.D.) MASK/FIXTURE ETC.*C/P MOVE (CONTINUED)					001 MNPRC 002 02 003 BE01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19502N			
		B		D					

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
11. MODEL/DESIGN/SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN INNER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		MECHANIC SIGN OFF REQUIRED							
26 ✓	230	CHROME PLATE PISTON (UPPER SHORT AREA O.D.) TO ALLOW GRINDING BACK TO O.D. 4.562/4.563 CLASS III TYPE II TIME OUT _____ DATE OUT _____					001 MNPRC 002 02 003 CP01 008 CD020		
		MECHANIC SIGN OFF REQUIRED *C/P MOVE							
26B ✓	235	BAKE 4 HRS AT 350-400F WITHIN 4 HRS OF CHROME PLATE DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
26 ✓	238	PREPARE FOR CHROME PLATE OF METERING PIN I.D. SEAL AREA, MASK/FIXTURE/ ETC. *C/P MOVE MECHANIC SIGN OFF REQUIRED					001 MNPRC 002 02 003 BE01 005 X8343061		
26 ✓	240	CHROME PLATE METERING PIN I.D. SEAL AREA TYPE II CLASS III TO GRIND BACK TO 4.258/4.252 TIME OUT _____ DATE OUT _____					001 MNPRC 002 02 003 CP01 005 X8343061		
		MECHANIC SIGN OFF REQUIRED *C/P MOVE					008 CI010		
26B ✓	250	BAKE 4 HRS AT 350F TO 400F WITHIN 4 HRS OF CHROME PLATE DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
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1. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL DESIGN SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN INNER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "C"	
8	260	FINISH GRIND INNER CYLINDER (LONG AREA O.D.) GRIND TO O.D. 4.995/4.997 32 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE					001 MNPRB 002 03 003 GE06		
8	270	FINISH GRIND INNER CYLINDER (UPPER SHORT AREA). GRIND TO O.D. 4.562/4.563 32 RMS *C/P MOVE					001 MNPRB 002 03 003 GE06		
8	280	FINISH GRIND METERING PIN I.D. SEAL AREA GRIND TO I.D. 4.258/4.252 4S2-59-3 PAGE 2-90 32 RMS *C/P MOVE					001 MNPRB 002 01 003 G101 005 X8745255		
26B	290	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT ***** *C/P MOVE				M	001 MNPRB 002 06 003 ML04		
26B	305	VAPOR DEGREASE *C/P MOVE					001 MNPRC 002 03 003 DG01		
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED (CONTINUED)				M	001 MNPRB 002 06 003 ZS01		
31. FINAL DESTINATION		32. COORDINATION/INITIATING RCC SIGNATURE/DATE				33. DOCUMENT/BN			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED		
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL				
13. SERIAL NUMBER			14. NOUN INNER CYLINDER							
15. DISPATCH STATION		16. PERF RCC/OP NO		17. WORK TO BE ACCOMPLISHED			18. MECHANIC		19. "P"	
				HERE, TAKE PRODUCTION COUNT *C/P MOVE						
				AXLE ATTACH LUG AREA I.D. *C/P MOVE					001 MNPWW 002 08 003 DG02	
				AXLE ATTACH LUG AREA INSIDE 45 TO 55 PSI PRESSURE *C/P MOVE					001 MNPWW 002 08 003 BL01	
				AXLE ATTACH LUG INSIDE .004/.007 BOND COAT. SPRAY WITH METCOLOY #2 SUFFICIENT TO ALLOW MACHINING TO 3.999/4.000 APPLY AF SEALER 50-50 WITH APT THINNER *C/P MOVE					001 MNPWW 002 08 003 FS11	
69		350		AXLE ATTACH LUG FLAME SPRAY. MACHINE TO I.D. 3.990/3.992 BREAK SHARP EDGES. CHAMFER .060/.090 X 45 125 RMS *C/P MOVE					001 MNPRA 002 04 003 MH02 005 X832691	
69		355		CROSS BOLT HOLE OVERSIZE (BUSHING REPAIR) MACHINE OVERSIZE TO CLEANUP I.D. .686/.707 125 RMS *C/P MOVE					001 MNPRA 002 04 003 MV03	
8		358		HONE AXLE ATTACH LUG FOR FINAL SPRAY ONLY. 3.999/4.000 64 RMS POROSITY ACCEPTABLE. *C/P MOVE					001 MNPRA 002 01 003 HV02 005 X8120573	
26		360		VAPOR DEGREASE *C/P MOVE					001 MNPRA 002 03 003 DG01	
26		363		PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE					001 MNPRA 002 01 003 BL02	
21. FINAL DESTINATION			22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH		FUNCTIONAL CODE		A		C		19502N.		
				B		D				

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2. JOB ORDER NO.		3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
7. PART NUMBER		8. TECH DATA			9. ITEM SERIAL NO.
10. MODEL-DESIGN-SERIES		11. STOCK NUMBER		12. OPTIONAL	
13. SERIAL NUMBER		14. NOUN INNER CYLINDER			
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED		18. MECHANIC	19. "P" "Q"
26 ✓	365	CAD PLATE INNER CYL TYPE II CLASS I 2.4 SQ FT AT 120-168 AMPS TIME OUT _____ DATE OUT _____ *C/P MOVE			001 MNPRC 002 03 003 CA01
26B ✓	370	BAKE 23 HRS AT 350F TO 400F WITHIN HRS OF PLATING  DATE IN: _____ TIME: _____  DATE OUT: _____ TIME: _____ *C/P MOVE			001 MNPRC 002 02 003 BK01
26 ✓	375	IRIDITE *C/P MOVE			001 MNPRC 002 02 003 IR01
	.65	***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT ***** *C/P MOVE		M	001 MNPRC 002 06 003 ML04
26 ✓	383	VAC I.V.D. ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 370 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING I.V.D. OPTION *C/P MOVE			001 MNPRC 002 03 003 IV01
26 ✓	387	ALODINE IVU ALUM PLATE CLASS 1A *C/P MOVE			001 MNPRC 002 03 003 TA01
69 ✓	389	MACHINE TURNUE ARM ATTACH BUSHING .0005/.0025 PRESS FIT. FINISH SIZE I.D. 1.4973/1.5001 (CONTINUED)			001 MNPRC 002 04 003 LE00
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE			23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A C			19502N
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2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN INNER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		125 RMS OVER-ALL FACE TO FACE 5.995/5.998 *C/P MOVE							
69 ✓	390	TORQUE ARM ATTACH LUG BUSHING INSTALLATION 3G61603-111 USE SEALANT MIL-S-81733 FINISH I.D. 1.4973/1.5001 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 3G61603-111						001 MNPRA 002 04 003 BE01	
69 ✓	395	MACHINE TOW LUG BUSHING, PRESS FIT .0005/.0025 FINISH SIZE I.D. .750/ .755 125 RMS *C/P MOVE						001 MNPRA 002 04 003 LE00	
69 ✓	400	TOW LUG BUSHING INSTALLATION 3G61603-219 USE MIL-S- 81733 FINISH BUSHING I.D. .750/.755 125 RMS *C/P MOVE P/N 3G61603-219						001 MNPRA 002 04 003 BE01	
69 ✓	405	MACHINE AXLE ATTACH LUG BUSHING, PRESS FIT .002/.004 FINISH I.D. SIZE 3.992/3.995 CHAMFER BOTH ENDS. 125 RMS *C/P MOVE						001 MNPRA 002 04 003 LE00	
69 ✓	410	AXLE ATTACH LUG BUSHING INSTALLATION P/N 3G61603-201 USE SEALANT MIL-S- 81733, DRILL CROSS BOLT HOLE USING EXISTING HOLE IN AREAS WHERE BUSHING IS NOT BACKED BY BASE METAL, IT MAY BE UP TO .003 UNDERSIZE. 125 RMS *C/P MOVE						001 MNPRA 002 04 003 BE01	
(CONTINUED)									
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19502N			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN INNER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		P/N 3661603-201							
69 ✓	412	AXLE ATTACH LUG FINISH I.D. 3.992/ 3.995 125 RMS *C/P MOVE					001 MNPRA 002 04 003 MH02 005 X8633691		
69 ✓	415	COUNTER BORE AXLE ATTACH LUG HOLE 125 RMS *C/P MOVE					001 MNPRA 002 04 003 MV02		
69 ✓	418	MACHINE AXLE CROSS BOLT HOLE BUSHING, PRESS FIT .001/.003 I.D. FINISH SIZE .625/.628 125 RMS *C/P MOVE					001 MNPRA 002 04 003 LE00		
69 ✓	420	AXLE CROSS BOLT HOLE BUSHING INSTALLATION MANUFACTURE 4130/4330M STEEL HT 180,000/200,000 PSI OR BUSH P/N 3661603-227 USE MIL-S-81733, FINISH BUSHING I.D. .625/.628 125 RMS. INSTALL BUSHING FLUSH TO .005 INCH BELOW SURFACE. RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE					001 MNPRA 002 04 003 BE01		
		P/N 3661603-227							
B ✓	430	HONE AXLE ATTACH LUG; HONE TO 3.999/ 4.000 64 RMS POROSITY ACCEPTABLE MAINTAIN 32 RMS *C/P MOVE					001 MNPRA 002 01 003 HV02 005 X8120573		
26 ✓	432	VAPOR DEGREASE *C/P MOVE					001 MNPRA 002 03 003 DG01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN INNER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26BP ✓	435	BRUSH CAD PLATE I.D. OF AXLE ATTACH BUSHING IAW MIL-C-8837 TYPE II CLASS III OR MIL-STD-865 *C/P MOVE					001 MNPRC 002 02 003 BP01		
26 ✓	438	IRIDIUM *C/P MOVE					001 MNPRC 002 02 003 IR01		
26BP ✓	440	BRUSH NICKEL PLATE TORQUE ARM BUSHINGS. APPLY NICKEL TO FACE OF BUSHINGS. MAINTAIN FACE TO FACE OF 5.995/5.999. *C/P MOVE					001 MNPRC 002 02 003 BP01		
	447	PRE-PAINT *C/P MOVE					001 MNPRC 002 09 003 PP01		
	450	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *REQD* *C/P MOVE					001 MNPRC 002 06 003 MU01		
	460	FINAL PRODUCT VISUAL INSPECTION *REQD* *C/P MOVE					001 MNPRC 002 06 003 MU01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
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2. JOB ORDER NO. 74521A		3. QUANTITY		4. PRODUCTION SEC/RCC MNP GP		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER 3G61032-107				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES C141 NOSE		11. STOCK NUMBER 1620009272599		12. OPTIONAL AF DRWG 3G61032 AND SUPPLEMENTS 4S-1-182/4S2-59-3					
13. SERIAL NUMBER		14. NOUN AXLE		<b>74521A</b>					
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 F.M.P.I. IAW MIL-STD-1949 P/O NO1561							
		BAKE IAW 4S-1-182 MAOI 74-12 FPI IAW MIL-STD-6866 TEMPER ETCH IAW MIL-STD-867							
		SHOT PEEN IAW MIL-S-13165 CHROME PLATE IAW MIL-STD-150 CAD PLATE IAW MIL-STD-870 STRIP CHROME IAW MIL-STD-871							
		ALODINE IAW MIL-C-5541 VAC IVD ALUM PLATE IAW MIL-C-83488A *****UNIT COST \$2047.51***** 4340 STEEL 260,000/280,000 PSI							
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLIC- ABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
				(CONTINUED)					
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19503N			
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7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN AXLE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		4.001/4.002 AXLE JOURNALS LARGE (2 EA) O.D. 3.8113/3.8123							
		AXLE JOURNALS SMALL (2 EA) O.D. 3.7488/3.7498							
		CROSS BOLT HOLE I.D. 0.625/0.626 WEAR 0.627 CHECK THREADS ON I.D. *C/P MOVE							
		* * * * * N O T E * * * * * * A MINIMUM OF 2 FMPI OPERATIONS * * MUST BE ACCOMPLISHED * * * * * *							
26 ✓	035	VAPOR DEGREASE *C/P MOVE						001 MNPRC 002 03 003 DG01	
26 ✓	040	STRIP CAD *C/P MOVE						001 MNPRC 002 02 003 CS01	
26 ✓	045	STRIP RUST *C/P MOVE						001 MNPRC 002 02 003 CS02	
69 ✓	050	NICK AND BURR USE A 1 INCH BLEND RADIUS TO PARENT METAL IAW PARA 2-34 DO NOT EXCEED WALL THICKNESS IAW FIG. 2-22. *C/P MOVE						001 MNPRA 002 04 003 BE01	
69 ✓	060	RECENTER AXLE IF NECESSARY *C/P MOVE						001 MNPRA 002 04 003 LE08	
69 ✓	061	GRIND THREADS IAW BLUE PRINT 3061032 *C/P MOVE						001 MNPRA 002 04 003 LE08	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN AXLE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
69	070	CROSS BOLT HOLE OVERSIZE REPAIR FOR BUSHING MACHINE OVERSIZE TO CLEANUP WITHIN 0.745/0.802 125RMS *C/P MOVE					001 MNHRA 002 04 003 MV03		
26	080	STRIP CHROME FROM CENTER JOURNALS (3 EA) *C/P MOVE					001 MNHRC 002 02 003 SC02		
26	090	STRIP CHROME FROM LARGE JOURNALS (2 EA) *C/P MOVE					001 MNHRC 002 02 003 SC02		
26	100	STRIP CHROME FROM SMALL JOURNALS (2 EA) *C/P MOVE					001 MNHRC 002 02 003 SC02		
8	110	FIRST GRIND AXLE CENTER JOURNALS (3 EA) GRIND TO CLEANUP NOT TO EXCEED MIN OD 3.986 32 RMS *C/P MOVE					001 MNHRC 002 03 003 GE07		
8	120	FIRST GRIND LARGE JOURNALS (2 EA) GRIND TO CLEANUP NOT TO EXCEED MIN OD 3.7963 32 RMS *C/P MOVE					001 MNHRC 002 03 003 GE07		
8	130	FIRST GRIND SMALL JOURNALS (2 EA) GRIND TO CLEANUP NOT TO EXCEED MIN OD 3.7338 32 RMS *C/P MOVE					001 MNHRC 002 03 003 GE07		
8	140	POLISH O.D. AREAS BETWEEN JOURNALS FOR CORROSION REMOVAL. REFER TO FIG 2-22 FOR LIMITATIONS MAINTAIN GIVEN RADIUS AND BREAK CORNERS .030/.060 R *C/P MOVE					001 MNHRC 002 03 003 GE07		
[REDACTED]						M	001 MNHRA 002 06 003 TE03		
TIME OUT _____ DATE OUT _____ (CONTINUED)									
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19503N			
		B		D					

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2 JOB ORDER NO.		3. QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13. SERIAL NUMBER			14 NOUN AXLE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****							
26B ✓	160	BAKE 4 HRS AT 350 TO 400F WITHIN 8 HRS OF ETCH  DATE: _____ TIME IN: _____						001 MNPRC 002 02 003 BK01	
		DATE: _____ TIME OUT: _____ *C/P MOVE							
		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****				M		001 MNPRC 002 06 003 ML04	
26 ✓	175	VAPOR DEGREASE *C/P MOVE						001 MNPRC 002 03 003 DG01	
26 ✓	180	SHOTPEEN CENTER JOURNALS (3 EA) 0.008/0.012 A2 100% SATURATION *C/P MOVE						001 MNPRC 002 01 003 SP02	
26 ✓	190	SHOTPEEN LARGE JOURNALS (2 EA) 0.008/0.012 A2 100% SATURATION *C/P MOVE						001 MNPRC 002 01 003 SP02	
26 ✓	200	SHOTPEEN SMALL JOURNALS (2 EA) 0.008/0.012 A2 100% SATURATION *C/P MOVE						001 MNPRC 002 01 003 SP02	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19503N			
		B		D					

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN AXLE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26 ✓	210	SHOTPEEN OUTER REWORKED AREAS BETWEEN JOURNALS 0.008/0.012 A2 100% SATURATION *C/P MOVE					001 MNPRC 002 01 003 SP02		
26 ✓	212	SHOTPEEN CROSS BOLT HOLES .008/.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26 ✓	215	PREPARE FOR CHROME PLATE MASK/ FIXTURE/ETC  MECHANIC SIGN OFF REQUIRED *C/P MOVE					001 MNPRC 002 02 003 BE01		
26 ✓	220	CHROME PLATE CENTER JOURNALS 3EA TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 4.001/4.002 TIME OUT _____ DATE OUT _____					001 MNPRC 002 02 003 CP01 008 CD010		
		*MECHANIC SIGNOFF REQUIRED----- *C/P MOVE							
26 ✓	230	CHROME PLATE LARGE JOURNALS 2EA TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 3.8113/3.8123 TIME OUT _____ DATE OUT _____					001 MNPRC 002 02 003 CP01 008 CD020		
		*MECHANIC SIGNOFF REQUIRED----- *C/P MOVE							
26 ✓	240	CHROME PLATE SMALL JOURNALS 2EA TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 3.7488/3.7498 TIME OUT _____ DATE OUT _____					001 MNPRC 002 02 003 CP01 008 CD010		
		*MECHANIC SIGNOFF REQUIRED----- *C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19503N			
		B		D					

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED				
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.				
10. MODEL-DESIGN-SERIES				11. STOCK NUMBER		12. OPTIONAL						
13. SERIAL NUMBER				14. NOUN AXLE								
15. DISPATCH STATION		16. PERF RCC/OP NO		17. WORK TO BE ACCOMPLISHED			18. MECHANIC		19. "P"		20. "Q"	
26B		250		BAKE 4 HRS AT 350 TO 400F WITHIN 4 HRS OF CHROME  DATE: _____ TIME IN: _____					001 MNPRC 002 02 003 BK01			
				DATE: _____ TIME OUT: _____ *C/P MOVE								
B		260		FINISH GRIND CENTER JOURNALS (3 EA) GRIND JOURNALS TO O.D. 4.001/4.002 32 RMS *C/P MOVE					001 MNPRH 002 03 003 GE07			
B		270		FINISH GRIND LARGE JOURNALS (2 EA) GRIND JOURNALS TO O.D. 3.8113/3.8123 32 RMS *C/P MOVE					001 MNPRB 002 03 003 GE07			
B		280		FINISH GRIND SMALL JOURNALS (2 EA) GRIND JOURNALS TO O.D. 3.7488/3.7498 32 RMS *C/P MOVE					001 MNPRB 002 03 003 GE07			
26B		290		BAKE 4 HRS AT 350-400F  DATE: _____ TIME IN: _____					001 MNPRC 002 02 003 BK01			
				DATE: _____ TIME OUT: _____ *C/P MOVE								
				*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****			M		001 MNPRH 002 06 003 ML04			
26		305		VAPOR DEGREASE *C/P MOVE					001 MNPRC 002 03 003 DG01			
21. FINAL DESTINATION				22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN				
DISPATCH		FUNCTIONAL CODE		A		C		19503N				
				B		D						

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL/DESIGN/SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN AXLE						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****				M	001 MNP NA 002 06 003 ZS01		
26	315	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE					001 MNP RC 002 01 003 BL02		
26	320	CAD PLATE AXLE TYPE II CLASS II 1.1 SQ FT AT 55-77 AMPS TIME OUT _____ DATE OUT _____ *C/P MOVE					001 MNP RC 002 03 003 CA01		
26B	330	BAKE 23 HRS AT 350 TO 400F WITHIN 4 HRS OF PLATING DATE: _____ TIME IN: _____					001 MNP RC 002 02 003 BK01		
		DATE: _____ TIME OUT: _____ *C/P MOVE							
26	335	IRIDITE *C/P MOVE					001 MNP RC 002 02 003 IR01		
	.65	*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****				M	001 MNP NA 002 06 003 ML04		
26	343	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 330 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK (CONTINUED)					001 MNP RC 002 03 003 IV01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19503N			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN AXLE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. P	20. Q	
		IS DONE, BEFORE USING IVD OPTION. *C/P MOVE							
26	347	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE					001 MNP RC 002 03 003 TA01		
69	349	MACHINE CROSS BOLT HOLE BUSHING .0005/.002 PRESS FIT					001 MNP RA 002 04 003 LE00		
69	350	CROSS BOLT HOLE BUSHING INSTALLATION P/N 3G61603-277 USE MIL-S-81733 IAW FIG 2-22 DETAIL C & B. FINISH I.D. 0.32570.326 32 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 3G61603-277					001 MNP RA 002 04 003 BE01		
	357	PRE-PAINT ALL SURFACES NOT CHROMED IAW DRWG 3G61032 *C/P MOVE					001 MNP GP 002 09 003 PP01		
	360	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958 *C/P MOVE					001 MNP GP 002 06 003 MU01		
	370	FINAL PRODUCT VISUAL INSPECTION *REQD* *C/P MOVE					001 MNP GP 002 06 003 MU01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19503N			
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC MNP GP	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER		8 TECH DATA 48-1-182 482-59-3 & DRWG 8241229		9 ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES C141 NOSE	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN OLEO TRUNNION	<b>79521A</b>

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
8340783-10		1620001947597 74521A			
8340783-30		N.S.L. 74521A			
	AAA		H		
	001	8340783-01 8340783-30			
		DISASSEMBLY/REMOVE BUSHINGS *C/P MOVE		001 MNP GW 002 02 003 LG02 005 X8745233 006 X8745235	
	*REQD*				
		CHEM CLEAN *C/P MOVE		001 MNP GW 002 03 003 AC02	
	*REQD*				
		BLAST CLEAN *C/P MOVE		001 MNP GW 002 03 003 BL01	
	*REQD*				
		STRIP ANODIZE *C/P MOVE		001 MNP GW 002 03 003 AN03	
	*REQD*				
		*C/P MOVE	M	001 MNP NA 002 05 003 ZY05	
	*REQD*				

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	19504N
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OLED TRUNNION						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		IAW 452-59-3 PARA 4-3 TO DETERMINE PART NUMBER. N O T E: OLD TRUNNIONS WERE MADE FROM 7079 T6 ALUMINUM NEW TRUNNIONS WERE MADE OF 7049 T73 ALUMINUM OLD TRUNNIONS WILL BE USED UNTIL NEW OLED TRUNNIONS ARE AVAILABLE. *C/P MOVE					001 MNP NA 002 05 003 EC04		
		E AND J INSPECTION					001 MNP GW 002 04 003 EI01		
		*REQD* CENTER CYLINDER ATTACH HOLE ID 6.1365/6.138							
		END TRUNNION SOCKET BUSHING I.D. 3.8130/3.815							
		END TRUNNION SOCKET HOLES ID 3.9985/4.000							
		CROSS BOLT HOLE (SMALL) ID .500/.501							
		CROSS BOLT HOLE (LARGE) BUSHING I.D. .625/.628 WEAR .6293							
		CROSS BOLT HOLE (LG) ID .8125/.8135							
		MOUNTING FLANGE HOLES ID .750/.751							
		MOUNTING FLANGE BUSHING I.D. .625/.6272 WEAR .628							
		AFT DOOR LEVER LUG HOLES ID .750/.751							
		AFT DOOR LEVER BUSHING ID .625/.627 WEAR .628							
		FWD DOOR LEVER LUG HOLES ID .625/.626							
		FWD DOOR LEVER BUSHING ID .500/.502 (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				C			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OLED TRUNNION						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		WEAR .5038 ACTUATOR LUG HOLE ID 1.000/1.001 ACTUATOR LUG BUSHING ID .8745/.8770 WEAR .8795							
		LOCAL NICK AND BURR ON CENTER HOLE ID .050 OVER 10% OF AREA *C/P MOVE NOTE: ANY OLED TRUNNIONS EXCEEDING T.O. CRITERIA WILL BE IDENTIFIED TO							
		ENGINEER ON AFIC FOR 103 STAT'NG CONDITION OF ITEM. ENGINEER WILL DETERMINE IF ITEM IS TO BE REWORKED PER DRWG 8241229.							
		***** NOTE ***** * A MINIMUM OF 2 FPI OPERATIONS * * MUST BE ACCOMPLISHED * *****							
69 ✓	030	REMOVE BUSHINGS THAT CANT BE REMOVED AT STATION 34 *C/P MOVE						001 MNHRA 002 04 003 BE01	
69 ✓	033	LOCALLY POLISH I.D. OF TRUNNION TO REMOVE CORROSION DO NOT EXCEED MINIMUM WALL DIMENSIONS. *C/P MOVE						001 MNHRA 002 04 003 BE01	
69 ✓	035	LOCALLY POLISH I.D. OF TRUNNION ENDS TO REMOVE CORROSION. *C/P MOVE						001 MNHRA 002 04 003 BE01	
69 ✓	040	NICK AND BURR EXTERNAL UP TO .075 DEEP IN A 2 INCH SQUARE AREA. CENTER HOLE ID CAN BE REWORKED IN LOCAL AREAS UP TO .020 DEEP NOT TO EXCEED 10% OF SURFACE *C/P MOVE						001 MNHRA 002 04 003 BE01	
69 ✓	045	TRUNNION CENTER HOLE REWORK INCREASE I.D. OF TRUNNION TO 6.1410/6.1440. IF THIS OPERATION COMPLIED (CONTINUED)						001 MNHRA 002 04 003 MH02 005 X833699	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19504N			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OLEO TRUNNION						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		WITH F.P.I., SHOTPEEN, ANODIZE AND PAINT PER FIGURE 2-20 FLAG NOTE (33) (OPER. 400) SHOULD BE COMPLIED WITH IF REWORK EXCEEDS ABOVE DIMENSIONS							
		CANCELL OPERATION 400. *C/P MOVE							
69 ✓	050	END TRUNNION SOCKET (LEFT END) OVERSIZE REPAIR. OVERSIZE TO CLEANUP DO NOT EXCEED THE MINIMUM WALL THICKNESS 125 RMS *C/P MOVE					001 MNHRA 002 04 003 MH02 005 X8633699		
69 ✓	060	END TRUNNION SOCKET (RIGHT END) OVERSIZE REPAIR. OVERSIZE TO CLEANUP DO NOT EXCEED THE MINIMUM WALL THICKNESS 125 RMS *C/P MOVE					001 MNHRA 002 04 003 MH02 005 X8633699		
69 ✓	070	END CROSS BOLT HOLE (SMALL) OVERSIZE REPAIR. O/S TO CLEANUP *C/P MOVE					001 MNHRA 002 04 003 DR01		
69 ✓	075	ROLL BURNISH END CROSS BOLT HOLE (SMALL) .0005/.001 COMPRESSION. DONT EXCEED MAX ID .551 125 RMS *C/P MOVE					001 MNHRA 002 04 003 BE01		
69 ✓	080	END CROSS BOLT HOLE (LARGE) OVERSIZE REPAIR. O/S TO CLEANUP *C/P MOVE					001 MNHRA 002 04 003 DR01		
69 ✓	085	ROLL BURNISH END CROSS BOLT HOLE (LARGE) .0005/.001 COMPRESSION. DONT EXCEED MAX ID .8635 125 RMS *C/P MOVE					001 MNHRA 002 04 003 BE01		
69 ✓	090	MOUNTING FLANGES BOLT HOLES (FWD END REPAIR) OVERSIZE TO CLEANUP *C/P MOVE					001 MNHRA 002 04 003 MV03		
69 ✓	095	ROLL BURNISH MOUNTING FLANGES BOLT HOLES (FWD END), DONT EXCEED MIN WALL IN GRAPH 125 RMS (CONTINUED)					001 MNHRA 002 04 003 BE01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19504N			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OLED TRUNNION						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*C/P MOVE							
69 ✓	100	MOUNTING FLANGE BOLT HOLES (AFT END) REPAIR OVERSIZE TO CLEANUP DO NOT EXCEED MINIMUM WALL IN GRAPH 125 RMS *C/P MOVE					001 MNFRA 002 04 003 MV03		
69 ✓	105	ROLL BURNISH MOUNTING FLANGE BOLT HOLES (AFT END) *C/P MOVE					001 MNFRA 002 04 003 BE01		
69 ✓	110	AFT DOOR LEVER LUG HOLE (RIGHT SIDE) REPAIR O/S TO CLEANUP DO NOT EXCEED MIN WALL THICKNESS IAW GRAPH 125 RMS *C/P MOVE					001 MNFRA 002 04 003 MH02		
69 ✓	115	ROLL BURNISH AFT DOOR LEVER LUG HOLE (RIGHT SIDE) *C/P MOVE					001 MNFRA 002 04 003 BE01		
69 ✓	120	AFT DOOR LEVER LUG HOLE (LEFT SIDE) REPAIR O/S TO CLEANUP DO NOT EXCEED MIN WALL THICKNESS IAW GRAPH 125 RMS *C/P MOVE					001 MNFRA 002 04 003 MH02		
69 ✓	125	ROLL BURNISH AFT DOOR LEVER LUG HOLE (LEFT SIDE) *C/P MOVE					001 MNFRA 002 04 003 BE01		
69 ✓	130	FWD DOOR LEVER LUG HOLE (RIGHT SIDE) REPAIR O/S TO CLEANUP DO NOT EXCEED MIN WALL THICKNESS IAW GRAPH 125 RMS *C/P MOVE					001 MNFRA 002 04 003 MH02		
69 ✓	135	ROLL BURNISH (FWD) DOOR LEVER LUG HOLE (RIGHT SIDE) *C/P MOVE					001 MNFRA 002 04 003 BE01		
69 ✓	140	FWD DOOR LEVER LUG HOLE (LEFT SIDE) REPAIR O/S TO CLEANUP DO NOT EXCEED MIN WALL THICKNESS IAW (CONTINUED)					001 MNFRA 002 04 003 MH02		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19504N			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OLED TRUNNION						
18. DISPATCH STATION	18. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		GRAPH 125 RMS *C/P MOVE							
69	145	ROLL BURNISH FWD DOOR LEVER LUG HOLE (LEFT SIDE) *C/P MOVE					001 MNFRA 002 04 003 BE01		
69	150	ACTUATOR LUG HOLE OVERSIZE REPAIR O/S TO CLEANUP DO NOT EXCEED MIN WALL THICKNESS IAW GRAPH 125 RMS *C/P MOVE					001 MNFRA 002 04 003 MH02		
69	155	ROLL BURNISH ACTUATOR LUG HOLE *C/P MOVE					001 MNFRA 002 04 003 BE01		
69	160	CENTER ATTACH HOLE REPAIR FOR FLAME SPRAY (FIRST REPAIR) O/S TO CLEANUP WITHIN JD 6.158/6.218 IF REPAIR REQUIRES MORE THAN .040 FLAME SPRAY REPAIR WITH BUSHING 125 RMS *C/P MOVE					001 MNFRA 002 04 003 MH02 005 X8633699		
69	170	CENTER ATTACH HOLE REPAIR FOR BUSHING (SECOND REPAIR) OVERSIZE TO CLEANUP IAW FIGURE 2-20, FLAG 21, THERE ARE 3 ALTERNATE METHODS GIVEN 125 RMS *C/P MOVE					001 MNFRA 002 04 003 MH02 005 X8633699		
26	180	VAPOR DEGREASE *C/P MOVE					001 MNFRA 002 03 003 DG01		
		*C/P MOVE ***** NOTE ***** (CONTINUED)				M	001 MNFRA 002 06 003 ZA02		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN					
DISPATCH	FUNCTIONAL CODE	A		C		19504N			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OLEO TRUNNION						
15. DISPATCH STATION	16. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****							
26	200	SHOTPEEN TRUNNION REWORKED AREAS *C/P MOVE					001 MNPRC 002 01 003 SP01		
26	202	SHOT PEEN CENTER ATTACH HOLE *C/P MOVE					001 MNPRC 002 01 003 SP01		
26	204	SHOT PEEN END TRUNNION SOCKET (RIGHT SIDE) *C/P MOVE					001 MNPRC 002 01 003 SP01		
26	206	SHOT PEEN END TRUNNION SOCKET (LEFT SIDE) *C/P MOVE					001 MNPRC 002 01 003 SP01		
26	210	POLISH LARGE CENTER, HOLE AFTER SHOTPEEN ONLY IF BUSHING IS REQUIRED REMOVE SHOTPEEN ROUGHNESS BUT NOT MORE THAN .002 MATERIAL *C/P MOVE					001 MNPRC 002 03 003 BE01		
26	220	POLISH TRUNNION END SOCKET (RT SIDE) AFTER SHOTPEEN. LIGHTLY POLISH TO REMOVE SHOTPEEN ROUGHNESS DO NOT REMOVE MORE THAN .002 MAT *C/P MOVE					001 MNPRC 002 03 003 BE01		
26	230	POLISH TRUNNION END SOCKET (LFT SIDE) AFTER SHOTPEEN. LIGHTLY POLISH TO REMOVE SHOTPEEN ROUGHNESS. DO NOT REMOVE MORE THAN .002 MAT *C/P MOVE					001 MNPRC 002 03 003 BE01		
		A FOR FLAME SPRAY *C/P MOVE					001 MNPRC 002 08 003 DG02		
		TO BE SPRAYED *C/P MOVE					001 MNPRC 002 08 003 BL01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A				C			
		B				D			
						19504N			

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED				
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.				
10. MODEL/DESIGN/SERIES				11. STOCK NUMBER		12. OPTIONAL						
13. SERIAL NUMBER				14. NOUN OLEO TRUNNION								
15. DISPATCH STATION		16. PERF RCC/OP NO		17. WORK TO BE ACCOMPLISHED			18. MECHANIC		19. "P"		20. "Q"	
				[REDACTED] TRUNNION CENTER HOLE SPRAY HOLE WITH METCO SF ALUMINUM SUFFICIENT TO ALLOW MACHINING TO ID OF 6.1365/6.138					001 MNHWW 002 08 003 FS09			
				***NOTE: DO NOT FLAME SPRAY I.D. CROSSBORE AREA. NO OVERSPRAY ALLOWED ON I.D. OF THE ARMS. *C/P MOVE								
69 ✓		250		CENTER CYLINDER ATTACH HOLE MACHINING OF SPRAY FINISH MACHINE TO ID 6.1365/6.138 62 RMS FIG 2-20 & SUPPLEMENTS *C/P MOVE					001 MNHRA 002 04 003 MH02 005 X8633699			
26 ✓		260		DEGREASE TRUNNION PRIOR TO ANODIZE *C/P MOVE					001 MNHRC 002 03 003 DG01			
26 ✓		270		ANODIZE TRUNNION COMPLETE TYPE II *C/P MOVE					001 MNHRC 002 03 003 AS03			
69 ✓		273		MACHINE CENTER ATTACH HOLE BUSHING PRESS FIR .0025/.005 USE MIL-S-81733 CHAMFER 45 DEG 125 RMS					001 MNHRA 002 04 003 LE00			
69 ✓		275		CENTER ATTACH HOLE BUSHING INSTALLATION P/N 3061603-203 INSTALL FLUSH TO .015 BELOW CHAMFER *C/P MOVE					001 MNHRA 002 04 003 RE01			
				P/N 3061603-203								
69 ✓		276		FINISH ID 6.1365/6.138 125 RMS *C/P MOVE					001 MNHRA 002 04 003 MH02 005 X8633699			
69 ✓		279		MACHINE END TRUNNION SOCKET SIDE BUSHING .001/.0035 PRESS FIT					001 MNHRA 002 04 003 LE00			
21. FINAL DESTINATION				22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN				
DISPATCH		FUNCTIONAL CODE		A		C		19504N				
				B		D						

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OLEO TRUNNION						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
69 ✓	280	END TRUNNION SOCKET (RT SIDE) BUSHING INSTALLATION P/N 3061603-205 USE SEALANT. MIL-S-81733 DRILL CROSS BOLT HOLE. P/N 3061603-205					001 MNPRA 002 04 003 BE01		
69 ✓	285	FINISH BUSHING ID 3.813/3.815 32 RMS PAGE 2-63 FIG 2-20 *C/P MOVE					001 MNPRA 002 04 003 BE01		
69 ✓	289	MACHINE END TRUNNION SOCKET (LEFT SIDE) BUSHING .0014/.0035 PRESS FIT 32 RMS					001 MNPRA 002 04 003 LE00		
69 ✓	290	END TRUNNION SOCKET (LEFT SIDE) BUSHING INSTALLATION P/N 30616-3-205 USE SEALANT MIL-S-81733 DRILL CROSS BOLT HOLE. REWORK LIMITS P/N 3061603-205					001 MNPRA 002 04 003 BE01		
69 ✓	295	FINISH BUSHING ID 3.813/3.815 32 RMS PAGE 2-63 FIG 2-20 RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE					001 MNPRA 002 04 003 BE01		
69 ✓	298	MACHINE END CROSS BOLT HOLE (SHAL) BUSHING .0005/.002 PRESS FIT 125 RMS USE MIL-S-81733					001 MNPRA 002 04 003 LE00		
69 ✓	299	END TRUNNION SOCKET (LEFT SIDE) BUSHING INSTALLATION P/N 3061603-205 FINISH LINE REAM ID .375/.3765 (CONTINUED)					001 MNPRA 002 04 003 BE01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19504N			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OLEO TRUNNION						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		125 RMS *C/P MOVE P/N 8121212-15							
69	305	MACHINE END CROSS BOLT HOLE (LARGE) BUSHING. USE MIL-S-81733, .002/.005 PRESS FIT 125 RMS					001 MNPRA 002 04 003 LE00		
69	310	END CROSS BOLT HOLE (LARGE) BUSHING INSTALLATION P/N 3G61603-137 FINISH LINE REAM TO ID .625/.628					001 MNPRA 002 04 003 BE01		
		125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 3G61603-137							
69	315	MACHINE MOUNTING FLANGE BOLT HOLE (FWD END) BUSHING .0005/.002 PRESS FIT 125 RMS					001 MNPRA 002 04 003 LE00		
69	320	MOUNTING FLANGE BOLT HOLE (FWD END) BUSHING INSTALLATION P/N 3G61603-221. NO PROTRUSION OF BUSHING ALLOW ON TOP SURFACE. USE MIL-S-81733. FINISH REAM I.D. .625/.627 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 3G61603-221					001 MNPRA 002 04 003 BE01		
69	325	MACHINE FLANGE BOLT HOLE (LARGE) BUSHING .0005/.002 PRESS FIT 125 RMS					001 MNPRA 002 04 003 LE00		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/IN			
DISPATCH	FUNCTIONAL CODE	A		C		19504N			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OLEO TRUNNION						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "O"	
69	330	MOUNTING FLANGE BOLT HOLE (AFT END) BUSHING INSTALLATION 3G61603-221 .0005/.002 PRESS FIT. NO PROTRUSION OF BUSHING ALLOW ON TOP SURFACE. USE MIL-S-81733 . FINISH REAM I.D. .625/.627 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 3G61603-221					001 MNPRA 002 04 003 BE01		
69	335	MACHINE AFT DOOR LEVER LUG HOLE (RIGHT SIDE) BUSHING .0005/.002 PRESS FIT 125 RMS ID FINISH SIZE .625/.627					001 MNPRA 002 04 003 LE00		
69	340	AFT DOOR LEVER LUG HOLE (RIGHT SIDE) BUSHING INSTALLATION 3G61603-225 USE MIL-S-81733 FINISH REAM ID .625/.627 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 3G61603-225					001 MNPRA 002 04 003 BE01		
69	345	MACHINE AFT DOOR LEVER LUG HOLE (LEFT SIDE) BUSHING .0005/.002 PRESS FIT 125 RMS FINISH SIZE .625/.627					001 MNPRA 002 04 003 LE00		
69	350	AFT DOOR LEVER LUG HOLE (LEFT SIDE) BUSHING INSTALLATION 3G61603-225 USE MIL-S-81733 FINISH REAM ID .625/.627 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED (CONTINUED)					001 MNPRA 002 04 003 BE01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				C			
		3				D			
						19504N			

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETE	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OLEO TRUNNION						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 3G61603-225							
69	355	MACHINE FWD DOOR LEVER LUG HOLE BUSHING .0005/.002 PRESS FIT 125 RMS FACE TO FACE .688/.693 ID FINISH SIZE .500/.502					001 MNPRA 002 04 003 LE00		
69	360	FWD DOOR LEVER LUG HOLE (RIGHT SIDE) BUSHING INSTALLATION OR 3G61603-135 OR 3G61603-225. USE MIL-S-81733					001 MNPRA 002 04 003 BE01		
		FINISH LINE REAM ID .500/.502 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED							
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 3G61603-135							
69	365	MACHINE FWD DOOR LEVER LUG FACE (LEFT SIDE) BUSHING .0005/.002 PRESS FIT FINISH ID SIZE .500/.502 125 RMS FACE TO FACE .6881/.693					001 MNPRA 002 04 003 LE00		
69	370	FWD DOOR LEVER LUG HOLE (LEFT SIDE) BUSHING INSTALLATION 3G61603-135 USE MIL-S-81733 FINISH ID .500/.502. 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED					001 MNPRA 002 04 003 BE01		
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 3G61601-135							
69	375	MACHINE ACTUATOR LUG BUSHING .0005/.002 PRESS FIT FINISH ID SIZE .8745/.877 125 RMS (CONTINUED)					001 MNPRA 002 04 003 LE00		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19504N			
		B		D					

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES				11. STOCK NUMBER		12. OPTIONAL			
13. SERIAL NUMBER				14. NOUN OLEO TRUNNION					
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		FACE TO FACE .875/.880							
69 ✓	380	ACTUATOR LUG BUSHING INSTALLATION REPLACE. USE MIL-S-81733 FINISH ID .8745/.877					001 MNPR 002 04 003 BE01		
		125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 8121212-17							
69 ✓	390	TRUNNIONS REWORKED FOR DRUG 8241229 WILL BE REIDENTIFIED AS FOLLOWS: STAMP P/N 8241229-30 ON THE RAISED AREA OF THE TRUNNION USING 1/8 INCH ROUND BOTTOM STAMP. *C/P MOVE					001 MNPR 002 04 003 BE01		
26 ✓	395	ALODINE CENTER LUG BUSHING AFTER MACHINE *C/P MOVE					001 MNPR 002 03 003 TA01		
	400	ONLY IF OPERATION 045 HAS BEEN ACCOMPLISHED. PAINT CENTER TRUNNION I.D. WITH TWO COATES OF EPOXY PRIMER *C/P MOVE					001 MNPR 002 09 003 PP01		
	410	PAINT TRUNNION END I.D. WITH EPOXY PRIMER. *C/P MOVE					001 MNPR 002 09 003 PP01		
	425	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958 (CONTINUED)					001 MNPR 002 06 003 MU01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19504N			
		B		D					

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETE	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL DESIGN SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OLEO TRUNNION						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "O"	
		*C/P MOVE							
	430 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					001 MNRGP 002 06 003 MU01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A				19504N			
		B				124			

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2 JOB ORDER NO. 74521A		3 QUANTITY		4 PRODUCTION SEC/RCC MNPGP		5 DATE SCHED		6 DATE COMPLETED	
7. PART NUMBER 3G61014-101				8. TECH DATA 4S-1-182 4S2-59-3				9. ITEM SERIAL NO.	
10 MODEL DESIGN SERIES C141 NOSE			11 STOCK NUMBER 1620000271196			12 OPTIONAL <b>74521A</b>			
13. SERIAL NUMBER			14 NOUN TRUNNION PIN						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		GOVERNING DIRECTIVES: AFMCR 66-51 MANOI 66-3 F.M.P.I. IAW MIL-STD-1949 P/O NO1561 STRIP CHROME IAW MIL-STD-871 GRIND IAW MIL-STD-866 TEMPER ETCH IAW MIL-STD-867 SHOT PEEN IAW MIL-S-13165 CHROME PLATE IAW MIL-STD-1501 FPI IAW MIL-STD-6866 CAD PLATE IAW MIL-STD-870 BAKE IAW 4S-1-182 MAOI 74-12 VAC I.V.D. ALUM IAW MIL-C-83488A ALODINE IAW MIL-C-5541 ***4140 STEEL 180,000/200,000 PSI** ***UNIT COST 3G61014-101 \$189.43** *** UNIT COST 3G61039-101 \$115.30** ALL PERSONNEL INVOLVED IN THE WORK PROCESSES IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK B OF THIS AFMCR FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				C			
		B				D			
						19505N			

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2 JOB ORDER NO.		3. QUANTITY		4 PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13. SERIAL NUMBER			14 NOUN TRUNNION PTN						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		WARNING							
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	3661014-101							
		DISASSEMBLE *C/P MOVE						001 MNP GW	
	*REQD*							002 02	
								003 LG02	
								005 X8745235	
								006 X8745233	
		CHEM CLEAN *C/P MOVE						001 MNP GW	
	*REQD*							002 03	
								003 SL01	
		BLAST CLEAN *C/P MOVE						001 MNP GW	
	*REQD*							002 03	
								003 BL07	
		BAKE 4 HRS AT 350-400F						001 MNP GW	
	*REQD*	DATE IN _____ TIME IN _____						002 03	
		(CONTINUED)						003 BK03	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19505N			
		B		D					

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN TRUNNION PIN						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		[REDACTED] *C/P MOVE				M	001 MNPNA 002 05 003 MS03		
		[REDACTED] E AND I INSPECTION					001 MNPBW 002 04 003 EI01		
		*REQD* PIN LARGE DIAMETER O.D. 3.8105/3.8125 WEAR 3.8098							
		PIN SMALL DIAMETER O.D. 2.3097/2.3112 WEAR 2.3092 *C/P MOVE							
26	032	VAPOR DEGREASE *C/P MOVE					001 MNP RC 002 03 003 DG01		
26	034	STRIP CAD *C/P MOVE					001 MNP RC 002 02 003 CS01		
26	036	STRIP RUST *C/P MOVE					001 MNP RC 002 02 003 CS02		
26	040	STRIP CHROME FROM LARGE DIAMETER *C/P MOVE					001 MNP RC 002 02 003 SC02		
26	050	STRIP CHROME FROM SMALL DIAMETER *C/P MOVE					001 MNP RC 002 02 003 SC02		
26		[REDACTED] MINIMUM O.D. 3.800 32 RMS P/N 3G61014-101 (CONTINUED)					001 MNP RB 002 02 003 GE01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19505N			
		B		D					

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2 JOB ORDER NO.		3. QUANTITY		4 PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13. SERIAL NUMBER			14 NOUN TRUNNION PIN						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*C/P MOVE							
8	070	FIRST GRIND SMALL DIAMETER CLEANUP MINIMUM 0.002-2.280 32 RMS P/N 3661014-101 *C/P MOVE						001 MNP RB 002 02 003 GE01	
8	085	GRIND PIN HOLE TO DIA OF .375/.376 CONCENTRIC & PREPENDICULAR TO CENTER LINE 2.285/2.305 FROM END TO CENTER OF HOLE 32 RMS *C/P MOVE						001 MNP RB 002 02 003 BE01	
		[REDACTED]				M		001 MNP NA 002 06 003 TE03	
		TIME OUT _____ DATE OUT _____ *C/P MOVE							
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *							
26B	100	BAKE 4 HRS AT 350 TO 400F WITHIN 8 HRS OF ETCH						001 MNP RC 002 02 003 BK01	
		DATE IN _____ TIME IN _____							
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		[REDACTED]				M		001 MNP NA 002 06 003 ML04	
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *							
26	115	VAPOR DECREASE *C/P MOVE						001 MNP RC 002 03 003 DG01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				C			
		B				D			
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2 JOB ORDER NO.		3. QUANTITY		4 PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN TRUNNION PIN						
15 DISPATCH STATION	16 PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26 ✓	120	SHOT PEEN LARGE DIA INTENSITY .008/.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26 ✓	122	SHOT PEEN SMALL DIA INTENSITY OF .008/.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26 ✓	125	PREPARE FOR CHROME PLATING OF LARGE O.D. FIXTURE/MASK/ETC. MECHANIC SIGN OFF REQUIRED					001 MNPRC 002 02 003 BE01		
26 ✓	130	CHROME PLATE LARGE O.D. SUFFICIENT TO GRIND BACK TO 3.8105/3.8125 TYPE II CLASS III MECHANIC SIGN OFF REQUIRED *C/P MOVE					001 MNPRC 002 02 003 CP01 008 CD010		
26 ✓	135	PREPARE FOR CHROME PLATING OF SMALL O.D. FIXTURE/MASK/ETC. MECHANIC SIGN OFF REQUIRED					001 MNPRC 002 02 003 BE01		
26 ✓	140	CHROME PLATE SMALL O.D. SUFFIC- IENT TO GRIND BACK TO FINISHED DIM- ENSION OF 2.3097/2.3112 TYPE II CLASS III					001 MNPRC 002 02 003 CP01 008 CD020		
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED *C/P MOVE							
26B ✓	150	BAKE 4 HRS AT 350 TO 400F WITHIN 4 HRS OF CHROME  DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19505N			
		B		D					

## 19505N WORK CONTROL DOCUMENT (MEDS)

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NCUN TRUNNION PIN	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
8 ✓	160	FINISH GRIND LARGE DIAMETER O.D. 3.8105/3.8125. CONCENTRIC WITHIN .001 32 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNPRB 002 02 003 GE01	
8 ✓	170	FINISH GRIND SMALL DIAMETER O.D. 2.3097/2.3112. CONCENTRIC WITHIN .001. 32 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNPRB 002 02 003 GE01	
26B ✓	180	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
		*C/P MOVE ***** NOTE ***** IF LAST NOT OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *****	M	001 MNPRNA 002 06 003 ML04	
26 ✓	195	VAPOR DECREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
		*C/P MOVE ***** NOTE ***** (CONTINUED)	M	001 MNPRNA 002 06 003 ZS01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
21A. DISPATCH	21B. FUNCTIONAL CODE	22A. A	22B. C	19505N
		22A. B	22B. D	

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN TRUNNION PIN						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****							
26 ✓	205	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE					001 MNPRC 002 01 003 BL02		
26 ✓	210	CAD PLATE TYPE I CLASS II .5 SQ FT AT 25-35 AMPS TIME OUT _____ DATE OUT _____ *C/P MOVE					001 MNPRC 002 03 003 CA01		
26B ✓	220	BAKE 24 HRS AT 350 TO 400F WITHIN 4 HRS OF CAD  DATE IN _____ TIME IN _____  DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
26 ✓	221	IRIDITE *C/P MOVE					001 MNPRC 002 02 003 IR01		
	165	*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****				M	001 MNPRC 002 06 003 ML04		
26 ✓	224	VAC I.V.D. ALUM OPTIONAL NOTE: 24 HR BAKE AND F.M.P.I. MUST BE ACCOMPLISH ED PRIOR TO THIS OPTION *C/P MOVE					001 MNPRC 002 03 003 IV01		
26 ✓	225	ALODINE I.V.D. ALUM *C/P MOVE					001 MNPRC 002 03 003 TA01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19505N			
		B		D					

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN TRUNNION PIN						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. P"	20. "Q"	
	227 *REQD*	PRE-PAINT *C/P MOVE					001 MNP GP 002 09 003 PP01		
	230 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 950 *C/P MOVE					001 MNP GP 002 06 003 SA03		
	240 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					001 MNP GP 002 06 003 SA03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19505N			
		B		D					

\* U.S. GOVERNMENT PRINTING OFFICE: 1965-546-103

19508N

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2. JOB ORDER NO. 74521A		3. QUANTITY		4. PRODUCTION SEC/RCC MNP GP		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER 3G61039-101				8. TECH DATA 4S-1-182 4S2-59-3				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES C141 NOSE			11. STOCK NUMBER 1620007575889			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN TRUNNION PIN (THREADED)			74521A			
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		GOVERNING DIRECTIVES: AFLCR 66-51 MANQI 66-3 F.M.P.I. IAW MIL-STD-1949 P/O N01561 STRIP CHROME IAW MIL-STD-871 GRIND IAW MIL-STD-866 TEMPER ETCH IAW MIL-STD-867 SHOT PEEN IAW MIL-S-13165 CHROME PLATE IAW MIL-STD-1501 FPI IAW MIL-STD-6866 CAD PLATE IAW MIL-STD-870 BAKE IAW 4S-1-182 MAOI 74-12 VAN I.V.D. ALUM IAW MIL-C-83488A ALODINE IAW MIL-C-5541 ***4140 STEEL 180,000/200,000 PSI** ***UNIT COST 3G61014-101 \$189.43*** *** UNIT COST 3G61039-101 \$115.30*** ALL PERSONNEL INVOLVED IN THE WORK PROCESSES IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19508N			
		B		D					

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN TRUNNION PIN (THREADED)						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		PERSONNEL, ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQUI* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	3061039-101							
		DISASSEMBLE				FC/P MOVE		001 MNP GW	
	*REQUI*							002 02	
								003 LG02	
								005 X8745235	
								006 X8745233	
		CHEM CLEAN				FC/P MOVE		001 MNP GW	
	*REQUI*							002 03	
								003 SL01	
		BLAST CLEAN				FC/P MOVE		001 MNP GW	
	*REQUI*							002 03	
								003 BL 07	
		TAKE 4 HRS AT 350-400F						001 MNP GW	
	*REQUI*	DATE IN _____ TIME IN _____						002 03	
		DATE OUT _____ TIME OUT _____						003 BK03	
		*C/P MOVE							
	*REQUI*					M		001 MNP NA	
								002 05	
								003 MS03	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				19508N			
		B							
		C							
		D							

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2 JOB ORDER NO.		3. QUANTITY		4 PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13. SERIAL NUMBER			14 NOUN TRUNNION PIN (THREADED)						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		E AND I INSPECTION					001 MNPRGW		
	*REQD*	PIN LARGE DIAMETER O.D. 3.8105/3.8125 WEAR 3.8098					002 04	003 EI01	
		PIN SMALL DIAMETER O.D. 2.3097/2.3112 WEAR 2.3092							
		PIN I.D. LARGE AREA 3.452 MAX							
		PIN I.D. SMALL AREA 1.600 MAX							
		PIN I.D. THREADED AREA 1.030 MAX							
		CROSS BOLT HOLE I.D. 0.625/0.626							
		*C/P MOVE							
26 ✓	032	VAPOR DEGREASE				*C/P MOVE		001 MNPRC	
								002 03	
								003 DC01	
26 ✓	034	STRIP CAD				*C/P MOVE		001 MNPRC	
								002 02	
								003 CS01	
26 ✓	036	STRIP RUST				*C/P MOVE		001 MNPRC	
								002 02	
								003 CS02	
26 ✓	040	STRIP CHROME FROM LARGE DIAMETER						001 MNPRC	
		*C/P MOVE						002 02	
								003 SC02	
26 ✓	050	STRIP CHROME FROM SMALL DIAMETER						001 MNPRC	
		*C/P MOVE						002 02	
								003 SC02	
26 ✓	060	FIRST GRIND LARGE DIAMETER CLEANUP						001 MNPRB	
		MINIMUM O.D. 3.800 32 RMS						002 02	
		3G61039-101						003 GE01	
		*C/P MOVE							
26 ✓	060	FIRST GRIND SMALL DIAMETER CLEANUP						001 MNPRB	
		MINIMUM O.D. 2.305 32 RMS						002 02	
		P/N 3G61039-101 THREADED PIN						003 GE01	
		(CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19508N			
		B		D					

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN TRUNNION PIN (THREADED)						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*C/P MOVE							
8	085	GRIND CROSS BOLT HOLE TO CLEAN UP NOT TO EXCEED .0641" MAX *C/P MOVE					001 MNPFB 002 02 003 BE01		
		TIME OUT _____ DATE OUT _____ *C/P MOVE				M	001 MNPNA 002 06 003 TE03		
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****							
26B	100	BAKE 4 HRS AT 350 TO 400F WITHIN 8 HRS OF ETCH  DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		TIME OUT _____ DATE OUT _____ *C/P MOVE				M	001 MNPNA 002 06 003 ML04		
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****							
26	115	VAPOR DEGREASE *C/P MOVE					001 MNPRC 002 03 003 IG01		
26	120	SHOT PEEN LARGE DIA INTENSITY .008/.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19508N			
		B		D					

\* U.S. GOVERNMENT \* OFFICE 100-846-125



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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN TRUNNION P.I.N (THREADED)						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26 ✓	122	SHOT PEEN SMALL DIA INTENSITY OF .008/.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26 ✓	125	PREPARE FOR CHROME PLATING OF LARGE O.D. FIXTURE/MASK/ETC. MECHANIC SIGN OFF REQUIRED					001 MNPRC 002 02 003 BE01		
26 ✓	130	CHROME PLATE LARGE O.D. SUFFICIENT TO GRIND BACK TO 3.8105/3.8125 TYPE II CLASS III MECHANIC SIGN OFF REQUIRED					001 MNPRC 002 02 003 CP01 008 CD010		
		*C/P MOVE							
26 ✓	135	PREPARE FOR CHROME PLATING OF SMALL O.D. FIXTURE/MASK/ETC. MECHANIC SIGN OFF REQUIRED					001 MNPRC 002 02 003 BE01		
26 ✓	140	CHROME PLATE SMALL O.D. SUFFICIENT TO GRIND BACK TO FINISHED DIM- ENSION OF 2.3097/2.3112 TYPE II CLASS III					001 F C 002 C 003 CP01 008 CD020		
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED *C/P MOVE							
26B ✓	150	BAKE 4 HRS AT 350 TO 400F WITHIN 4 HRS OF CHROME					001 MNPRC 002 02 003 BK01		
		DATE IN _____ TIME IN _____							
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		3.8105/3.8125. CONCENTRIC WITHIN .001 32 RMS (CONTINUED)					001 MNPRC 002 02 003 GE01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19508N			
		B		D					

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN TRUNNION P.IN (THREADED)						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS							
		*C/P MOVE							
8	170	FINISH GRIND SMALL DIAMETER D.D. 2.3097/2.3112. CONCENTRIC WITHIN .001. 32 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE					001 MNP RB 002 02 003 GE01		
26B	180	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNP RC 002 02 003 BK01		
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *****				M	001 MNP NA 002 06 003 ML04		
26	195	VAPOR DEGREASE *C/P MOVE					001 MNP RC 002 03 003 DG01		
		*C/P MOVE ***** NOTE ***** (CONTINUED)				M	001 MNP NA 002 06 003 ZS01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19508N			
		B		D					

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## 19508N WORK CONTROL DOCUMENT (MEDS)

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2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO.		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN TRUNNION PIN (THREADED)						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****							
26 ✓	205	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE					001 MNPRC 002 01 003 BL02		
26 ✓	210	CAD PLATE TYPE I CLASS II .5 SQ FT AT 25-35 AMPS TIME OUT _____ DATE OUT _____ *C/P MOVE					001 MNPRC 002 03 003 CA01		
26B ✓	220	BAKE 24 HRS AT 350 TO 400F WITHIN 4 HRS OF CAD  DATE IN _____ TIME IN _____  DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
26 ✓	221	IRIDITE *C/P MOVE					001 MNPRC 002 02 003 IR01		
	.65	*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****				M	001 MNPRC 002 06 003 ML04		
26 ✓	224	VAC I.V.D. ALUM OPTIONAL NOTE: 24 HR BAKE AND F.M.P.I. MUST BE ACCOMPLISH ED PRIOR TO THIS OPTION *C/P MOVE					001 MNPRC 002 03 003 IV01		
26 ✓	225	ALODINE I.V.D. ALUM *C/P MOVE					001 MNPRC 002 03 003 TA01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19508N			
		B		D					

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN TRUNNION PIN (THREADED)						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
	227 *REQD*	PRE-PAINT *C/P MOVE					001 MNRGP 002 09 003 PP01		
	230 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *C/P MOVE					001 MNRGP 002 06 003 SA03		
	240 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					001 MNRGP 002 06 003 SA03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19508N			
		B		D					

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC MNPGP		5. DATE SCHED		6. DATE COMPLETED					
7. PART NUMBER				8. TECH DATA 4S-1-182 4S2-59-3				9. ITEM SERIAL NO.					
10. MODEL-DESIGN-SERIES C141 NOSE			11. STOCK NUMBER			12. OPTIONAL <b>74521A</b>							
13. SERIAL NUMBER			14. NOUN LOWER BEARING										
15. DISPATCH STATION P/N 3G61224-101 115689A		16. PERF RCC/OP NO		17. WORK TO BE ACCOMPLISHED NSN C/N 1620001257860 74521A			18. MECHANIC		19. "P"		20. "Q"		
				***** UNIT COST: \$114.30 *****									
				GOVERNING DIRECTIVES: AFLCR 66-51 MANOT 66-3									
				F.P.I. IAW MIL-STD-6866									
				STRIP ANODIZE IAW MIL-STD-871									
				ANODIZE IAW MIL-A-8625									
				ALODINE IAW MIL-C-5541									
				DRY FILM LUBE IAW MIL-L-46010									
				FLAME SPRAY IAW MIL-STD-869									
				*****ALUMINUM*****									
				ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.									
				* COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C-P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.									
				WARNING									
				MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.									
				(CONTINUED)									
21. FINAL DESTINATION			22. COORDINATION/INITIATING RCC SIGNATURE/DATE			23. DOCUMENT/BN							
DISPATCH		FUNCTIONAL CODE		A		C		19510N					
				B		D							

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN LOWER BEARING						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	3G61226-101 115687A							
		DISASSEMBLE *C/P MOVE						001 MNPBW 002 02 003 LG02 005 X8745235 006 X8745233	
	*REQD*								
		DEGREASE ONLY *C/P MOVE						001 MNPBW 002 02 003 LG02	
	*REQD*								
		*C/P MOVE				M		001 MNPNA 002 05 003 ZY05	
	*REQD*								
		E AND I INSPECTION						001 MNPBW 002 04 003 EI01	
	*REQD*	BEARING O.D. 5.7450/5.7480 WEAR 5.7440							
		BEARING I.D. 5.000/5.003 WEAR 5.006 *C/P MOVE * * * * * N O T E * * * * *							
		E & I INSPECTION MACHINING AND FLAME SPRAY REPAIR EXCEEDS THE COST OF THIS ITEM DO NOT REWORK THIS PART IF OUT OF TOLERANCE. IF BEARING HAS BEEN FLAME SPRAYED AND IS WITHIN DIMEN. SPECIFIED A DRY FILM LUBE AND ALO-							
		(CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19510N			
		B		D					

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN LOWER BEARING						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		DINE REPAIR IS AUTHORIZED. *C/P MOVE							
26 ✓	022	APPLY DRY FILM LUG TO FLAME SPRAYED I.D. MIL-L-46010 *C/P MOVE							
26 ✓	024	ALDOINE O.D. MIL-C-5541 *C/P MOVE RETURN TO STATION 34A FOR ASSEMBLY.							
69 ✓	025	IF FABROID I.D. IS DAMAGED REMOVE FABROID AND REPAIR WITH FLAME SPRAY							
69 ✓	030	MACHINE I.D. TO REMOVE FLAME SPRAY. DO NOT EXCEED 5.148 125/250 RMS *C/P MOVE						001 MNFRA 002 04 003 LE00 005 X8745165	
26 ✓	040	STRIP OLD ANODIZE *C/P MOVE						001 MNFRC 002 03 003 AN04	
26A		<div style="background-color: black; width: 100px; height: 15px; margin-bottom: 5px;"></div> *C/P MOVE ***** NO I E ***** IF LAST ND1 OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *****						001 MNFRA 002 06 003 2602	
26 ✓	050	ANODIZE BEARING TYPE II CLASS I COMPLETE *C/P MOVE						001 MNFRC 002 03 003 AS03	
69 ✓		<div style="background-color: black; width: 100px; height: 15px; margin-bottom: 5px;"></div> REPAIR BEARING I.D. TO REMOVE ANODI- ZE 5.140/5.150, MAINTAIN CONCENTRICITIES AND 125/250 RMS (CONTINUED)						001 MNFRA 002 04 003 LE00	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A				C			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES C141 Nos 5			11. STOCK NUMBER			12. OPTIONAL 74521A			
13. SERIAL NUMBER			14. NOUN LOWER BEARING						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		BREAK SHARP EDGES *C/P MOVE							
		[REDACTED] *C/P MOVE					001 MNPWW		
		[REDACTED] LUMINUM OXID OR A 50/50 MIXTURE OF G-16 AND G-25) NOTE: MASK ALL SURFACES EXCEPT I.D. REMOVE ALL GRID FROM I.D. *C/P MOVE					002 08		
		[REDACTED] FLAME SPRAY METCO SPRAYBRONZE A-A 4.825/4.925 USE 15 GAGE WIRE *C/P MOVE					003 DG02		
		[REDACTED] FLAME SPRAY I.D. .004/.007 BOND COAT FLAME SPRAY METCO SPRAYBRONZE A-A 4.825/4.925 USE 15 GAGE WIRE *C/P MOVE					001 MNPWW		
		[REDACTED] FINISH MACHINE FLAME SPRAY INSIDE. FINISH BEARING DIAMETER I.D. 5.000/5.003. MAINTAIN A 64 RMS OR BETTER SURFACE FINISH. RADIUS BEARING INSIDE EDGES TO .040/.060 AFTER MACHINING. HEAT BEARING TO .110/130F AND APPLY GRAPHITE GREASE MIL-G-7187 TO FLAME SPRAYED SURFACE LET BEARING COOL TO ROOM TEMPERATURE AND WIPE OFF EXCESS GREASE. RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED					002 08		
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS					003 BL01		
		*C/P MOVE					001 MNPWW		
		[REDACTED] 090 FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 (CONTINUED)					002 08		
		*REQD:					003 FS07		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL DESIGN SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN LOWER BEARING						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*C/P MOVE							
	100 *REQDY	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					001 MNR GP 002 06 003 SA03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19510N			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NAME STEERING COLLAR						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		E AND I INSPECTION					001 MNPBW		
	*REQD*	COLLAR I.D. 6.500/6.502 WEAR 6.506					002 04		
		COLLAR FACE TO FACE 5.245/5.255					003 EI01		
		COLLAR TORQUE ARM HOLES I.D. 1.4375/1.4386							
		COLLAR TORQUE ARM BUSHING I.D. 1.2474/1.2500 WEAR 1.2505 *C/P MOVE							
		***** N O T E ***** * A MINIMUM OF 2 FMPI OPERATIONS * * MUST BE ACCOMPLISHED * *****							
26	032	VAPOR DECREASE *C/P MOVE					001 MNPRC		
							002 03		
							003 DG01		
26	035	STRIP CAD *C/P MOVE					001 MNPRC		
							002 02		
							003 CS01		
26	040	STRIP RUST *C/P MOVE					001 MNPRL		
							002 02		
							003 CS02		
29	045	EXTERNAL DEFECT REMOVAL UP TO 0.02 DEEP BLEND WITH 1 INCH MIN RADIUS EXCEPT BUSHING HOLE & GEAR TEETH *C/P MOVE					001 MNPRA		
							002 04		
							003 BE01		
		TORQUE ARM HOLE REPAIR CLEANUP HOLES WITHIN MIN WALL DIMENSIONS PER FIG 2-25 FIGURE 2-25 125 RMS *C/P MOVE					001 MNPRA		
							002 04		
							003 BE01		
26	055	STRIP CHROME FROM INSIDE *C/P MOVE					001 MNPRL		
							002 02		
							003 SC02		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STEERING COLLAR						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26 ✓	060	STRIP CHROME FROM FACES *C/P MOVE					001 MNPRC 002 02 003 SC02		
8 ✓	070	FIRST GRIND COLLAR INSIDE TO REMOVE CHROME OR TO LAMINATE. MAX DIAMETER I.D. 6.517 BREAK CORNERS .090 16 RMS *C/P MOVE					001 MNPRB 002 02 003 GI01 005 X8852125		
8 ✓	080	FIRST GRIND COLLAR FACES TO REMOVE CHROME OR TO LAMINATE. MINIMUM ID. 5.230 32 RMS *C/P MOVE					001 MNPRB 002 02 003 GS01 005 XB745179		
		[REDACTED]				M	001 MNPRNA 002 06 003 TE03		
		TIME OUT _____ DATE OUT _____ *C/P MOVE							
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****							
26B ✓	100	BAKE 4 HRS AT 350F TO 400F WITHIN 8 HRS OF ETCH  DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		[REDACTED]				M	001 MNPRNA 002 06 003 ML04		
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****							
26 ✓	115	VAPOR DEGREASE *C/P MOVE					001 MNPRC 002 03 003 DG01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STEERING COLLAR						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26 ✓	120	SHOT PEEN I.D. .008/.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26 ✓	125	SHOT PEEN FACES .008/.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26 ✓	128	PREPARE COLLAR ID FOR CHROME PLATE FIXTURE/MASK/ETC. MECHANIC SIGN OFF REQUIRED *C/P MOVE					001 MNPRC 002 02 003 BE01		
26 ✓	130	CHROME PLATE COLLAR I.D. 2 EA JOURNALS SUFFICIENT TO GRIND BACK TO DIMENSION OF 6.500/6.502 TYPE II CLASS II DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED *C/P MOVE					001 MNPRC 002 02 003 CP01 008 CI010		
26B ✓	150	BAKE 4 HRS AT 350 - 400F WITHIN 4 HRS OF CHROME PLATE DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
26 ✓	153	PREPARE COLLAR FACE FOR CHROME PLATE OR FLASH CHROME PLATE, MASK/FIXTURE/ ETC. *C/P MOVE MECHANIC SIGN OFF REQUIRED					001 MNPRC 002 02 003 BE01		
26 ✓	155	CHROME PLATE OR FLASH CHROME PLT COLLAR FACE 1EA ONLY TYPE II CLASS II DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED *C/P MOVE					001 MNPRC 002 02 003 CP01 008 CO010		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
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2. JOB ORDER NO.		3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
7. PART NUMBER			8. TECH DATA		9. ITEM SERIAL NO.
10. MODEL-DESIGN-SERIES		11. STOCK NUMBER		12. OPTIONAL	
13. SERIAL NUMBER		14. NOUN STEERING COLLAR			
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED		18. MECHANIC	19. "P"
26B	157	BAKE 4 HRS AT 350 - 400F WITHIN 4 HRS OF CHROME PLATE DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE			001 MNPRC 002 02 003 BK01
8	160	FINISH GRIND COLLAR INSIDE DIA. JOURNAL FINISH DIA I.D. 6.500/6.502 16 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			001 MNPRB 002 02 003 GI02 005 X8852125
8	170	FINISH GRIND COLLAR FACE 1 EA ONLY 125 RMS *C/P MOVE			001 MNPRB 002 02 003 GS01 005 X8745179
26B	180	BAKE 4 HRS AT 350F TO 400F DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE			001 MNPRC 002 02 003 BK01
26	200	PREPARE COLLAR FACE FOR CHROME PLATE OR FLASH CHROME PLATE MASK/FIXTURE/ ETC. *C/P MOVE MECHANIC SIGN OFF REQUIRED			001 MNPRC 002 02 003 BE01
26	210	CHROME PLATE OR FLASH CHROME COLLAR FACE 1EA SUFFICIENT TO GRIND BACK TO 5.245/5.255 TYPE II CLASS I DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED *C/P MOVE			001 MNPRC 002 02 003 CP01 008 C0020
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STEERING COLLAR						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26B	220	BAKE 4 HRS AT 350-400F WITHIN 4 HRS OF CHROME PLATE  DATE IN _____ TIME IN _____  DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNP RC 002 02 003 BK01		
8	240	FINISH GRIND COLLAR FACE TO FACE 5-245/5-255-125-RMS *C/P MOVE					001 MNP RB 002 02 003 GS01 005 X8745179		
26B	250	BAKE 4 HRS AT 350-400F  DATE IN _____ TIME IN _____  DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNP RC 002 02 003 BK01		
		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *****				M	001 MNP NA 002 06 003 ML04		
26	265	VAPOR DECREASE *C/P MOVE					001 MNP RC 002 03 003 DG01		
26B		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *****				M	001 MNP NA 002 06 003 ZS01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19511N			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STEERING COLLAR						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26 ✓	275	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED *C/P MOVE					001 MNPRC 002 01 003 BL02		
26 ✓	280	CAD PLATE TYPE II CLASS II 1.1 SO FT AT 55-77 AMPS TIME OUT _____ DATE OUT _____ *C/P MOVE					001 MNPRC 002 03 003 CA01		
26B ✓	290	BAKE 23 HRS AT 350-400F WITHIN 4 HRS OF CAD  DATE IN _____ TIME IN _____  DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. * *****				M	001 MNPRC 002 06 003 ML04		
26 ✓	304	VAPOR DECREASE *C/P MOVE					001 MNPRC 002 03 003 DG01		
26 ✓	307	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 290 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION *C/P MOVE					001 MNPRC 002 03 003 IV01		
26 ✓	310	DRY FILM LUBE GEAR TEETH ONLY *C/P MOVE					001 MNPRC 002 03 003 EL01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STEERING COLLAR						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26B	315	BAKE 1 HR AT 400F AFTER DRY FILM LUBE DATE IN _____ TIME IN _____					001 MNP RC	002 02	
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
26	318	IRIDITE *C/P MOVE					001 MNP RC	002 02	
							003 IR01		
26	319	ALODINE IVI ALUM PLATE CLASS 1A *C/P MOVE					001 MNP RC	002 03	
							003 TA01		
69	320	MACHINE TORQUE ARM LUG BUSHING FACE TO FACE 5.737/5.742 *C/P MOVE					001 MNP RA	002 04	
							003 LE00		
69	325	TORQUE ARM LUG BUSHING INSTALLATION PRESS #1 .0005/.0025. FINISH ID 1.2474/1.250 125 RMS USE SEALANT MIL-S-81733					001 MNP RA	002 04	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS							
		*C/P MOVE P/N 8121212-33							
	340	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *REQD* *C/P MOVE					001 MNP GP	002 06	
							003 MU01		
	350	FINAL PRODUCT VISUAL INSPECTION *REQD* *C/P MOVE					001 MNP GP	002 06	
							003 MU01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19511N			
		B		D					

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2. JOB ORDER NO. 74521A		3. QUANTITY		4. PRODUCTION SEC/RCC MNP GP		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER 3G61027-101				8. TECH DATA 4S-1-182 4S2-59-3				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES C141 NOSE		11. STOCK NUMBER 1620000110320				12. OPTIONAL <b>74521A</b>			
13. SERIAL NUMBER		14. NOUN STEERING PLATE							
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		***** UNIT COST: \$626.70 ***** GOVERNING DIRECTIVES: AFLCR 66-51 MANDI 66-3 F.M.P.I. IAW MIL-STD-1949 P/O NO1561 BAKE IAW 4S-1-182 MAOI 74-12 SHOT PEEN IAW MIL-S-13165 SULFAMATE NICKEL IAW MIL-STD-868 FPI IAW MIL-STD-6866 TEMPER ETCH IAW MIL-STD-867 *****STEEL 180,000/200,000 PSI***** ALL PERSONNEL INVOLVED IN THE WORK PROCESSES IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED & ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES & HAZARDS CONTAINED IN THE BASIC TECH ORDER (T.O.) AND T.O. SUPPS. REFERENCED. THE APPLICABLE T.O.S & SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. **W A R N I N G** MANY OF THE FOLLOWING REPAIR PROCED- URES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POT- ENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS & PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURY. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	3G61027-101							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19512N			
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2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN STEERING PLATE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		DISASSEMBLE *C/P MOVE					001 MNHGW		
	*REQD*						002 02		
							003 LFG2		
							005 X8745233		
							006 X8745235		
		CHEM CLEAN *C/P MOVE					001 MNHGW		
	*REQD*						002 03		
							003 SL01		
		BLAST CLEAN *C/P MOVE					001 MNHGW		
	*REQD*						002 03		
							003 BL07		
		BAKE 4 HRS AT 350-400F					001 MNHGW		
	*REQD*	DATE IN _____ TIME IN _____					002 03		
		DATE OUT _____ TIME OUT _____					003 BK03		
		*C/P MOVE							
		*C/P MOVE				M	001 MNHNA		
	*REQD*						002 05		
							003 MS03		
		E & I INSPECTION					001 MNHGW		
	*REQD*	LARGE I.D. 6.250/6.252 WEAR 6.254					002 04		
		NOTE: PITTING PERMISSIBLE 1AW					003 EI01		
		492-59-3 IN LARGE ID							
		CYLINDER ATTACH HOLES I.D.							
		.9375/.9385 WEAR .9397							
		*C/P MOVE							
		***** NOTE *****							
		* A MINIMUM OF 2 FMPI OPERATIONS *							
		* MUST BE ACCOMPLISHED *							
		(CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A				C			
						19512N			
		B				D			

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## 19512N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

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2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN STEERING PLATE						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		*****							
26 ✓	030	VAPOR DEGREASE *C/P MOVE					001 MNPRC 002 03 003 DG01		
26 ✓	035	STRIP ELECTROLESS NICKEL PLATE *C/P MOVE					001 MNPRC 002 03 003 SN01		
		C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *				M	001 MNPRC 002 06 003 ML04		
		*****							
8 ✓	039	IF REQUIRED REMOVE RAISED TURN BOSS AS OUTLINED IN T.O. PAGE 2-71 *C/P MOVE					001 MNPRC 002 02 003 BE01		
69 ✓	040	CYLINDER LUG HOLES OVERSIZE REPAIR MACHINE LUG HOLES O/S FOR A .040 MIN WALL BUSHING. MAX WALL THICKNESS IAW GRAPH IN 452-59-3 125RMS *C/P MOVE					001 MNPRC 002 04 003 MV02		
69 ✓	050	MACH KEYWAY SLOTS IAW T.O. 452-59-3 FIG 2-27 100% . USE FIXTURE TO DETERMINE THAT KEYWAYS ARE TRUE 32 RMS *C/P MOVE					001 MNPRC 002 04 003 MV02		
26 ✓	085	VAPOR DEGREASE *C/P MOVE					001 MNPRC 002 03 003 DG01		
26 ✓	095	SHOTPEEN LARGE ID *C/P MOVE					001 MNPRC 002 01 003 SP02		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/EN			
DISPATCH	FUNCTIONAL CODE	A		C		19512N			
		B		D					

\* U.S. GOVERNMENT PRINTING OFFICE: 1989-549-112

19512N

## WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

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2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9. ITEM SERIAL NO.	
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13. SERIAL NUMBER			14 NOUN STEERING PLATE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "O"	
26 ✓	150	PREPARE FOR SULFAMATE NICKEL PLATE, GLASS BLAST *C/P MOVE					001 MNPRC 002 01 003 BL03		
26 ✓	160	SULFAMATE NICKEL COMPLETE CLASS I NICKEL PLATE I.D. ENOUGH TO GRIND BACK TO 6.250/6.252 INCH DIM *C/P MOVE					001 MNPRC 002 03 003 NP01 008 NO010		
26B ✓	165	BAKE 23HRS AT 350-400F WITHIN 4 HRS OF PLATE DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
8 ✓	166	MEASURE I.D. 6.250/6.252 *C/P MOVE					001 MNPRB 002 02 003 RE01		
8 ✓	167	GRIND I.D. AS NECESSARY TO MEET DIMENSIONS OF 6.250/6.252 INCHES *C/P MOVE					001 MNPRB 002 02 003 GJ02		
26B ✓	168	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		*C/P MOVE							
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *				M	001 MNPRNA 002 06 003 ML04		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A				C			
		B				D			
						19512N			

## 19512N WORK CONTROL DOCUMENT (MEDS)

DATE 89045

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STEERING PLATE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
69 ✓	170	MACHINE CYLINDER LUG HOLES BUSHINGS MIN WALL .0040, PRESS FIT .001/.0015. FINISHED ID .9375/.9385 NOTE: KEEP DIM TO TOP TOLERANCE OF .93858 IF POSSIBLE. 125 RM3						001 MNHRA 002 04 003 LE00	
69 ✓	175	CYLINDER LUG HOLES BUSHING INSTALL- ATION. P/N 66C33001-69ST RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 66C33001-69ST						001 MNHRA 002 04 003 RE01	
	180	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *RECD* OF ALL PRECEDING OPERATIONS THIS 958 *C/P MOVE						001 MNHGP 002 06 003 MU01	
	190	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *RECD*						001 MNHGP 002 06 003 MU01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19512N			
		B		D					

19520N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

PAGE 1 OF 1 PAGES

2. JOB ORDER NO. 74521A		3. QUANTITY		4. PRODUCTION SEC/RCC MNP GP		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER 7530			8. TECH DATA 4S-1-182 4S2-59-3 & 4				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES C-141 NOSE			11. STOCK NUMBER LE			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN FILLER TUBE			74521A			
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 BRUSH CAD PLATE IAW MIL-STD-865							
		***** S T E E L ***** ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. * COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	7530983-01							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE					23. DOCUMENT/BN		
DISPATCH	FUNCTIONAL CODE	A					19520N		
		B					159		

## 19520N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED		
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL				
13. SERIAL NUMBER			14. NOUN FILLER TUBE							
15. DISPATCH STATION		16. PERF RCC/OP NO		17. WORK TO BE ACCOMPLISHED			18. MECHANIC		19. "P"	
		*REQD*		DISASSEMBLE *C/P MOVE					001 MNHGW 002 02 003 LG02 005 X8745235 006 X8745223	
		*REQD*		CLEAN *C/P MOVE					001 MNHGW 002 02 003 IG02	
		*REQD*		BLAST OR CHEM CLEAN *C/P MOVE					001 MNHGW 002 03 003 BL07	
				E & I PER TECH DATA *C/P MOVE						
69		030		MACHINE FILLER TUBE FOR STANDARD SIZE OD .9347/.936 "O" RING GROOVE .834/.836 IAW 452-59-3 PAGE 2-49 FIG "O" USING EXISTING "O" RING GROOVE AS GUIDE *C/P MOVE					001 MNHRA 002 04 003 LE00	
69		040		BRUSH CAD PLATE IAW MIL-STD-865 *C/P MOVE					001 MNHRA 002 04 003 BE01	
		050		FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *C/P MOVE					001 MNHGP 002 06 003 SA03	
		060		FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					001 MNHGP 002 06 003 SA03	
21. FINAL DESTINATION			22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH		FUNCTIONAL CODE		A		C		19520N		
				B		D				



PAGE 1 OF 1

		8	8	161
--	--	---	---	-----

7452, A

~~SECRET~~ MOVE

\*REQD\*

001	MNFGW
002	02
003	LG02
005	X8745235

DO NOT DESTROY

19524N

161

19524N

## WORK CONTROL DOCUMENT (MED)

DATE 8/20/15

PAGE 02 PAGE

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA			9. ITEM SERIAL NO.			
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN METERING PIN						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		DEGREASE ONLY *C/P MOVE					001 MNP GW		
	*REQD*						002 03		
							003 AC02		
		CHECK FOR CRACKS				M	001 MNP NA		
	*REQD*	*C/P MOVE					002 05		
							003 ZY05		
		E & 1 CHECK METERING PIN					001 MNP GW		
		I.D. 0.3800/0.3820					002 04		
	*REQD*	BASE O.D. 4.243/4.245 MAX WEAR 4.24					003 EI01		
		14.500 IN. LENGTH *C/P MOVE							
69	045	CHECK CONCENTRICITY					001 MNP RA		
	*REQD*	ALL DIAMETERS HAVING A COMMON AXIS					002 04		
		TO BE CONCENTRIC WITHIN .010 TIR					003 BE01		
		I.A.W. DRWG 3061091 *C/P MOVE							
	050	FINAL ACCEPTANCE OF WORK CONTROL					001 MNP GP		
	*REQD*	DOCUMENT FOR COMPLETENESS & ACCURACY					002 06		
		OF ALL PRECEDING OPERATIONS THIS 958					003 SA03		
		*C/P MOVE							
	060	FINAL PRODUCT VISUAL INSPECTION					001 MNP GP		
	*REQD*	*C/P MOVE					002 06		
							003 SA03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE					19524N			

\* U.S. GOVT \*

441 NLG

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

01/29/88

A-E046R-MM1-DY-M45 PAGE 0001

7452A

STRU, ASSY C-141 NLG

RCC MNFRA

4S2-59-3

TECH S S W F PF A/R REV

SUB	T	K	#R	A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A			
STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	PCT	C
501	S	E	JA	EA	1	J 84154	.86	PERCENT ENGR 98.8	REPAIR OUTER CYL C141N 405	12.93		11.12			
0001			JA	01	00		.00		PART NUMBER/NSN	.000	.000	.000		0	
0010								3661090-119	1620004419763						
0165			JA	01	15		.75		REMOVE TRUNNION LINK PIN	1.119	.126	.966		7	
0010 E						RDR-SU-V1	1.00	S-U DR PRS W-VISE FIXT DV-HD		.42803		.492			
0020 E						RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068			
0030 E						RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142			
0040 E						RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083			
0050 E						RML-BD-AC	1.00	BORE HOLE 1 X 1 1/2 GROUP 4		.35762		.411			
0060 E						RHW-TR-S1	1.00	DRILL TAP & INSTALL SLIMSERTAP & REMOVE LINK PIN		.06879		.079			
0080 E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011			
0170			JA	01	15		.21		EXTERNAL DEFECT REPAIR	.359	.011	.087		1	
0010 E						RHW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316			
0020 E						GTL-EP-A2	1.00	SET UP & DISMANTLE AIR DRILLS/U AIR GRINDER W/PAD/DISC		.00678		.007			
0030 E						RLG-RS-N3	1.00	NICK & BURR MED STRUT PART		.06711		.077			
0050 E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011			
0180			JA	01	15		.08		POLISH O.D.	.359	.004	.033		0	
0010 E						RHW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316			
0020 E						GTL-EP-A2	1.00	SET UP & DISMANTLE AIR DRILLS/U AIR GRINDER W/PAD/DISC		.00678		.007			
0030 E						RLG-RS-N3	1.00	NICK & BURR MED STRUT PART		.06711		.077			
0050 E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011			
			JA	01	15		.05		O/S DRAG ATTACH LUGS	1.887	.014	.109		1	
0010 E						RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST		1.03687		1.192			
0020 E						RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068			
0030 E						RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142			
0040 E						RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083			
0050 E						RML-BD-BA	2.00	BORE HOLE 1.5 X 1/2 GROUP 42EA LUGS		.29250		.672			
0070 E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011			
0155			JA	01	15		.08		O/S ACTUATOR LUGS	1.918	.023	.177		1	
0010 E						RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST		1.03687		1.192			
0020 E						RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068			
0030 E						RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142			
0040 E						RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083			
0050 E						RML-BD-BF	1.00	BORE HOLE 1.5 X 3 GROUP 4		.61649		.708			
0070 E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011			
0200			JA	01	15		.25		O/S TORQUE ARM LUG 4EA	1.634	.061	.470		4	
0010 E						RDR-SU-V1	1.00	S-U DR PRS W-VISE FIXT DV-HD		.42803		.492			
0020 E						RML-AL-CA	4.00	ALIGN HORIZ AXIS MAG BASE OCC FOR 4EA HOLES		.05917		.272			
0030 E						RML-AL-CB	4.00	ALIGN VERTICAL AXIS MAG BASE OCC FOR 4EA HOLES		.12351		.568			
0040 E						RML-AL-CC	4.00	ALIGN HOLE TO SPINDLE MAG BS OCC FOR 4EA HOLES		.07261		.334			
0050 E						RLA-RE-MB	4.00	REAM HOLE 1/2-1 5/8 DIA 1 DPOCC FOR 4EA HOLES		.04377		.201			
0070 E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011			
0205			JA	01	15		.21		O/S FILLER TUBE LUG	1.659	.052	.401		3	
0010 E						RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST		1.03687		1.192			
0020 E						RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068			
0030 E						RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142			
0040 E						RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083			
0050 E						RML-BD-AC	1.00	BORE HOLE 1 X 1 1/2 GROUP 4		.35762		.411			
0070 E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011			
0210			JA	01	15		.25		O/S STEER LUG 2EA.	1.042	.039	.300		2	
0010 E						RDR-SU-V1	1.00	S-U DR PRS W-VISE FIXT DV-HD		.42803		.492			
0020 E						RML-AL-CA	2.00	ALIGN HORIZ AXIS MAG BASE		.05917		.136			
0030 E						RML-AL-CB	2.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.284			

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0040 E	RML-AL-CC	2.00	ALIGN HOLE TO SPINDLE MAG BS	.07261	.167		
0050 E	RLA-RE-LC	2.00	REAM HOLE 1/4-1/2 DIA 1-1.5 2EA HOLES	.04715	.108		
0070 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011		
JA 01	15	.05	O/S LINK PIN HOLE	1.616	.012	.093 1	
0010 E	RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST	1.03687	1.192		
0020 E	RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE	.05917	.068		
0030 E	RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE	.12351	.142		
0040 E	RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS	.07261	.083		
0050 E	RML-BD-AB	1.00	BORE HOLE 1 X 1 GROUP 4	.31431	.361		
0070 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011		
0210	JA 01	15	.33	RADIUS STEERING FLANGE AREA	.847	.042	.322 2
0010 E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE	.49962	.574		
0020 E	RLA-RC-NG	1.00	RECESS 6-6.5 DIA. 1/8 DP G4	.11655	.134		
0030 E	RLA-RC-NH	3.00	RECESS 6-6.5 DIA. ADD 1/8 IN	.07383	.254		
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011		
0225	JA 01	15	.33	REMOVE PITTING STEER-FLANGE	.083	.004	.032 0
0010 E	GTL-EP-A2	1.00	SET UP & DISMANTLE AIR DRILLS/U AIR GRINDER W/PAD/DISC	.0678	.007		
0020 E	RLG-RS-N3	1.00	NICK & BURR MED STRUT PART	.06711	.077		
0040 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011		
0230	JA 01	15	.29	MACH 4 NEW KEY SLOTS	4.733	.206	1.579 12
0010 E	RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST	1.03687	1.192		
0020 E	RML-AL-BA	4.00	ALIGN HORIZ AXIS CLAMP 4 SLOTS	.05541	.254		
0030 E	RML-AL-BB	4.00	ALIGN VERTICAL AXIS CLAMP 4 SLOTS	.11975	.550		
0040 E	RML-BD-AM	4.00	BORE HOLE 1 X 6 IN GROUP 4 4 SLOTS	.74741	3.438		
0060 E	RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC	.00601	.006		
0235	JA 01	15	.33	REMOVE CORROSION RING GROOVE	.498	.025	.189 1
0010 E	RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL	.27525	.316		
0020 E	RLG-RS-P4	1.00	POLISH PLATED SURF OUTER CYL	.21297	.244		
0030 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011		
0245	JA 01	15	.13	MACH NEW KEYWAYS	4.737	.092	.708 5
0010 E	RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST	1.03687	1.192		
0020 E	RML-AL-BA	4.00	ALIGN HORIZ AXIS CLAMP 4 SLOTS	.05541	.254		
0030 E	RML-AL-BB	4.00	ALIGN VERTICAL AXIS CLAMP 4 SLOTS	.11975	.550		
0040 E	RML-BD-AM	4.00	BORE HOLE 1 X 6 IN GROUP 4 4 SLOTS	.74741	3.438		
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011		
0609	JA 01	15	.24	MACH BUSH DRAG ATTACH LUGS	.860	.031	.237 2
0010 E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE	.49962	.574		
0020 E	RLA-HP-C3	2.00	CHUCK SYMET PART IN 4 JAW 2EA BUSHINGS	.09095	.209		
0030 E	KML-TB-DC	2.00	DIA 1.00-1.50 REM .033-.250 2EA BUSHINGS	.08429	.193		
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011		
0610	JA 01	15	.24	INSTALL BUSH DRAG ATTACH LUG	.776	.028	.214 2
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES	.18517	.212		
0020 E	RBW-BU-B1	2.00	REBUSH A SET OF 2 BOSSES OCC FOR 2 MEN	.23835	.548		
0030 E	RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORESCHAMFER BUSHINGS 2EA	.10435	.120		
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011		
0615	JA 01	15	.24	MACH BUSH ACTUATOR LUGS	.727	.026	.201 2
0001 E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE	.49962	.574		
0002 E	RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW	.09095	.104		
0006 E	KML-TB-DC	1.00	DIA 1.00-1.50 REM .033-.250	.08429	.096		
0008 E	KML-TB-DD	2.00	DIA 1.5 REM .250 ADD INCH OCC FOR 2 ADD. INCHES	.02140	.049		
0070 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011		
0620	JA 01	15	.24	INSTALL BUSH ACTUATOR LUGS	1.244	.045	.344 3
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES	.18517	.212		
0020 E	RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES	.22231	.255		
0030 E	RBW-BU-C1	.50	CHAMFER SET OF BUSHING BORESCHAMFER 1EA BUSHING	.10435	.060		
0040 E	RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL S/U PORTABLE HONE	.27525	.316		
0050 N		1.00	HONE BUSHINGS	.50000	.575		
0070 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011		
0625	JA 01	15	.88	MACH BUSH TORQUE ARM LUGS 4E	1.165	.154	1.180 9
0002 E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE	.49962	.574		

0004 E	RLA-HP-C3	4.00	CHUCK SYMET PART IN 4 JAW	OCC FOR 4EA BUSHINGS	.09095	.418	
0008 E	KML-TB-CC	4.00	DIA .501-1.00 REM .033-.250	OCC FOR 4EA BUSHINGS	.07308	.336	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
JA 01	15	.88		INSTALL BUSH TORQUE ARM LUG	.848	.112	.859 7
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517	.212	
0020 E	RBW-BU-B2	2.00	REBUSH A SET OF 2 BOSSES	OCC FOR 4EA HOLES	.22231	.511	
0030 E	RBW-BU-C1	2.00	CHAMFER SET OF BUSHING BORES	OCC FOR 4EA HOLES	.10435	.240	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0635	JA 01	15	1.00	HONE TO FINISH SIZE	.443	.066	.509 4
0010 E	RDR-SU-V1	1.00	S-U DR PRS W-VISE FIXT DV-HDPRORATE S/U OVER 4 PARTS		.42803	.492	
0020 N		1.00		HONE TO FINISH SIZE	.00500	.005	
0070 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0640	JA 01	15	.79	MFG & INSTALL FILLER TUBE	.573	.068	.521 4
0010 E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962	.574	
0020 E	RLA-TD-DC	1.00	REMOVE .033 -.250 DIA OVER 1		.06341	.072	
0070 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0645	JA 01	15	.79	INSTALL FILLER TUBE BUSHING	.267	.032	.243 2
0030 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517	.212	
0040 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062	.023	
0050 E	RBW-BU-C1	.50	CHAMFER SET OF BUSHING BORES	OCC FOR 1EA	.10435	.060	
0070 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0648	JA 01	15	.92	MACH BUSH STEERING LUGS	.972	.134	1.029 8
0002 E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962	.574	
0004 E	RLA-HP-C3	2.00	CHUCK SYMET PART IN 4 JAW	2EA BUSHINGS	.09095	.209	
0008 E	KML-TD-DC	2.00	DIA 1.00-1.50 REM .033-.250	2EA BUSHINGS	.14068	.323	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0650	JA 01	15	.92	INSTALL BUSH STEERING LUG	.521	.072	.552 4
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517	.212	
0020 E	RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES		.22231	.255	
0030 E	RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435	.120	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0655	JA 01	15	1.00	HONE STEERING LUG BUSHING	.443	.066	.509 4
0010 E	RDR-SU-V1	1.00	S-U DR PRS W-VISE FIXT DV-HDPRORATE S/U OVER 4 PARTS		.42803	.492	
0020 N		1.00		HONE TO FINISH SIZE	.00500	.005	
0030 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0660	JA 01	15	1.00	MACHINE LINK PIN BUSHING	.667	.100	.768 6
0002 E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962	.574	
0004 E	RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095	.104	
0008 E	KML-TB-BC	1.00	DIA .251-.500 REM .033-.250		.06699	.077	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0665	JA 01	15	1.00	INSTALL LINK PIN	.267	.040	.308 2
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517	.212	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062	.023	
0030 E	RBW-BU-C1	.50	CHAMFER SET OF BUSHING BORES	OCC FOR 1EA BUSHING	.10435	.060	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0900			THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT				
0901			FOR THIS OPERATION WERE DETERMINED EITHER FROM				
0902			ACTUAL COUNT OR FROM REFERENCE TO T.O. SHOWN ABOVE				
0903			<				
9000	JA 01	15	.01	LABOR STANDARD HISTORY	.000	.000	.000 0
0010			PRIOR HISTORY ON OO-ALC 494 FORM				
0020			24JUN83 NEW OCC. FACTOR STUDY & REMOVE ALL RJPWF1				
0030			ELEMENTS <OLD STD> 13.80				
0031			27DEC84 2 YR REVIEW W/OCC CHANGE > OLD STD < 13.59				
0032			30JULY85 CHANGED SUB OP TO MATCH 958 NO TIME CHANG				
0899			J.CALDWELL TECH MANEAA				
0900			MANEL CLINTON BENTLEY MRP II 7-3255				

## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

01/29/88

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74521A STRUT ASSY C-141 NLG

RCC MNPRA

452-59-3

TECH S S W F FF A/R REV

SUB	T K	#R A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A	
STEP	D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
502	S	E	JA	EA 1	J 84154	.89 PERCENT ENGR 99.9	REPAIR INNER CYL C141N 405	9.69		8.63	
0001			JA	01	00	.00	PART NUMBER/NSN	.000	.000	.000	0
						3661089-111	1620004983226				
0045			JA	01	15	.08	NICK & BURR	.472	.006	.043	0
0010	E				REW-SU-G1	1.00 S/U FOR BENCH WORK GENERAL		.27525		.316	
0020	E				RLG-RS-N1	1.00 NICK & BURR V/L STRUT PARTS		.18732		.215	
0040	E				RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0050			JA	01	15	.16	O/S TORQUE ARM LUG	1.823	.044	.335	3
0010	E				RML-SU-V1	1.00 S/U VERT MILL BORE SMAL FXTR		.75732		.870	
0020	E				RML-AL-CA	1.00 ALIGN HORIZ AXIS MAG BASE		.05917		.068	
0030	E				RML-AL-CB	1.00 ALIGN VERTICAL AXIS MAG BASE		.12351		.142	
0040	E				RML-AL-CC	1.00 ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0050	E				RML-BD-CB	2.00 BORE HOLE 2 X 1 GROUP 4	2 LUGS	.40027		.920	
0070	E				RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0060			JA	01	15	.40	O/S AXLE ATTACH LUG F/SPRAY	3.322	.199	1.528	16
0010	E				RML-SU-V1	1.00 S/U VERT MILL BORE SMAL FXTR		.75732		.870	
0020	E				RML-AL-CA	1.00 ALIGN HORIZ AXIS MAG BASE		.05917		.068	
0030	E				RML-AL-CB	1.00 ALIGN VERTICAL AXIS MAG BASE		.12351		.142	
0040	E				RML-AL-CC	1.00 ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0050	E				RML-BD-GH	1.00 BORE HOLE 4 X 6 GROUP 4		2.29979		2.644	
0070	E				RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
70			JA	01	15	.12	O/S AXLE ATT LUG FOR BUSHING	3.322	.060	.458	5
0010	E				RML-SU-V1	1.00 S/U VERT MILL BORE SMAL FXTR		.75732		.870	
0020	E				RML-AL-CA	1.00 ALIGN HORIZ AXIS MAG BASE		.05917		.068	
0030	E				RML-AL-CB	1.00 ALIGN VERTICAL AXIS MAG BASE		.12351		.142	
0040	E				RML-AL-CC	1.00 ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0050	E				RML-BD-GH	1.00 BORE HOLE 4 X 6 GROUP 4		2.29979		2.644	
0070	E				RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0080			JA	01	15	.05	O/S CROSS BOLT LUGS	1.293	.010	.074	1
0010	E				RML-SU-V1	1.00 S/U VERT MILL BORE SMAL FXTR		.75732		.870	
0020	E				RML-AL-CA	1.00 ALIGN HORIZ AXIS MAG BASE		.05917		.068	
0030	E				RML-AL-CB	1.00 ALIGN VERTICAL AXIS MAG BASE		.12351		.142	
0040	E				RML-AL-CC	1.00 ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0050	E				RML-BD-AA	1.00 BORE HOLE 1 X 1/2 GROUP 4		.27100		.311	
0070	E				RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0090			JA	01	15	.08	O/S TOW LUGS	1.510	.018	.139	1
0010	E				RML-SU-V1	1.00 S/U VERT MILL BORE SMAL FXTR		.75732		.870	
0020	E				RML-AL-CA	1.00 ALIGN HORIZ AXIS MAG BASE		.05917		.068	
0030	E				RML-AL-CB	1.00 ALIGN VERTICAL AXIS MAG BASE		.12351		.142	
0040	E				RML-AL-CC	1.00 ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0050	E				RML-BD-AF	1.00 BORE HOLE 1 X 3 GROUP 4		.48755		.560	
0070	E				RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0350			JA	01	15	.40	MACH AXLE ATTACH LUG F/SPRAY	1.998	.120	.919	9
0010	E				RML-SU-V1	1.00 S/U VERT MILL BORE SMAL FXTR		.75732		.870	
0020	E				RML-AL-CA	1.00 ALIGN HORIZ AXIS MAG BASE		.05917		.068	
0030	E				RML-AL-CB	1.00 ALIGN VERTICAL AXIS MAG BASE		.12351		.142	
0040	E				RML-AL-CC	1.00 ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0050	E				RML-BB-GH	1.00 BORE HOLE 4 X 6 GROUP 2	MACH FLAME SPRAY	.97611		1.122	
0070	E				RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0355			JA	01	15	.16	O/S CROSS BOLT LUGS	1.293	.031	.238	2
0010	E				RML-SU-V1	1.00 S/U VERT MILL BORE SMAL FXTR		.75732		.870	
0020	E				RML-AL-CA	1.00 ALIGN HORIZ AXIS MAG BASE		.05917		.068	
0030	E				RML-AL-CB	1.00 ALIGN VERTICAL AXIS MAG BASE		.12351		.142	

0040 E		RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0050 E		RML-BD-AA	1.00	BORE HOLE 1 X 1/2 GROUP 4		.27100		.311	
060 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
	JA 01	15	.96	MACHINE TORQUE LUG BUSHING		.882	.127	.974	10
0002 E		RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0004 E		RLA-HP-C3	2.00	CHUCK SYNET PART IN 4 JAW 2EA BUSHINGS		.09095		.209	
0008 E		KML-TB-EC	2.00	DIA 1.50-2.00 REM .033-.250 2EA BUSHINGS		.09539		.219	
0050 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0390	JA 01	15	.96	INSTALL TORQUE LUG BUSHING		.523	.075	.578	6
0010 E		RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18669		.214	
0020 E		RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES		.22231		.255	
0030 E		RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435		.120	
0050 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0395	JA 01	15	1.00	MACHINE TOW LUG BUSHING		.701	.105	.806	8
0002 E		RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0004 E		RLA-HP-C3	1.00	CHUCK SYNET PART IN 4 JAW		.09095		.104	
0008 E		KML-TB-CC	1.00	DIA .501-1.00 REM .033-.250		.07308		.084	
0009 E		KML-TB-CD	2.00	DIA 1.0 REM .250 ADD INCH OCC FOR 2 ADD. INCHES		.01367		.031	
0050 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0400	JA 01	15	1.00	INSTALL TOW LUG BUSHING		.521	.078	.600	6
0010 E		RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517		.212	
0020 E		RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES		.22231		.255	
0030 E		RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435		.120	
0050 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0405	JA 01	15	.20	MACHINE AXLE ATTACH LUG BUSH		1.100	.033	.253	3
0001 E		RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0002 E		RLA-HP-C3	1.00	CHUCK SYNET PART IN 4 JAW		.09095		.104	
0004 E		KML-TB-HC	1.00	DIA 4.00-5.00 REM .033-.250		.15394		.177	
0005 E		KML-TB-HD	5.00	DIA 5.0 REM .250 ADD INCH OCC FOR 5 ADD. INCHES		.06928		.398	
0070 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0410	JA 01	15	.20	INSTALL AXLE ATTACH LUG BUSH		.252	.008	.058	1
0055 E		RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES		.22231		.255	
0060 E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0070 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0412	JA 01	15	.20	BUSH AXLE ATTACH LUGS		3.322	.100	.764	8
0010 E		RML-SU-V1	1.00	S/U VERT MILL BORE SMAL FXTR		.75732		.870	
0020 E		RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068	
0030 E		RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142	
0040 E		RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0050 E		RML-BD-GM	1.00	BORE HOLE 4 X 6 GROUP 4		2.29979		2.644	
0070 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0415	JA 01	15	.20	COUNTER BORE AXLE ATTACH BUS		3.322	.100	.764	8
0010 E		RML-SU-V1	1.00	S/U VERT MILL BORE SMAL FXTR		.75732		.870	
0020 E		RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068	
0030 E		RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142	
0040 E		RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0050 E		RML-BD-GM	1.00	BORE HOLE 4 X 6 GROUP 4		2.29979		2.644	
0070 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0418	JA 01	15	.72	MACH CROSS BOLT LUG BUSHING		.884	.095	.732	3
0002 E		RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0004 E		RLA-HP-C3	1.00	CHUCK SYNET PART IN 4 JAW		.09095		.104	
0006 E		RSG-JP-T1	1.00	JOB PREP GENERAL FOR S & M		.22079		.253	
0008 E		RLA-TB-CC	1.00	DIA .501-1.00 REMOVE .033-.250		.06285		.072	
0050 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
	JA 01	15	.72	INSTALL CROSS BOLT LUG BUSHI		.521	.056	.432	4
0010 E		RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517		.212	
0020 E		RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES		.22231		.255	
0030 E		RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435		.120	
0050 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	

0900

THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT

0901  
0902  
903

FOR THIS OPERATION WERE DETERMINED EITHER FROM  
ACTUAL COUNT OR FROM REFERENCE TO T.O. SHOWN ABOVE  
<

JA 01 15

.01

LABOR STANDARD HISTORY

.000 .000 .000 0

0010

PRIOR HISTORY ON OO-ALC 494 FORM

0020

24JUN83 NEW OCC. FACTOR STUDY & REMOVE ALL RJPPWF1  
ELEMENTS <OLD STD> 7.14

0030

0031

27DEC84 2 YR REVIEW W/OCC CHANGES > OLD STD < 9.05

0032

29JULY85 CHANGED SUB OP TO MATCH 958 NO TIME CHANG

0899

J.CALDWELL TECH MANEAA

0900

MANEL CLINTON BENTLEY MRP II 7-3255

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

<---X-----X--->

1234567890123456 ELSE PUT IN END

?



## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

01/29/88

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74521A STRUT ASSY C-141 NLG

RCC MNPRA

452-59-3

TECH S S W F PF A/R REV															
SUB	T K	#R A	FA	SUPPORT	OCC	DESCRIPTION					BASE	PFD	STD		
STEP	D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL				HOURS	TIME	HOURS	DLY PCT	
RA503	S	E	JA	EA 1	J	84154	.36	PERCENT ENGR	96.4	REPAIR AXLE C141 NLG	405	2.12		.76	
0001			JA	01	00		.00			PART NUMBER/NSN		.000	.000	.000	0
								3G61032-107	1620009272599						
0050			JA	01	15		.10			NICK & BURR		.331	.005	.038	2
0010 E								RRW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316	
0020 E								RLG-RS-N4	1.00	NICK & BURR SMALL STRUT PART		.04595		.052	
0040 E								RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0060			JA	01	15		.20			RECENTER AXLE 2EA ENDS		1.200	.036	.276	13
0010 E								RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0020 E								RLA-HP-C3	2.00	CHUCK SYMET PART IN 4 JAW 2 OCC FOR 2 AXLE ENDS		.09095		.209	
0030 N									1.00	S/U STEADY RESET		.13300		.152	
0040 E								RLA-HM-T2	1.00	INSTALL & ADJUST TOOL KDK BAR		.02972		.034	
0050 E								RLA-RC-GA	1.00	RECESS 3-3.5 DIA. 1/8 DP G1 RECENTER		.04385		.050	
0060 E								GQH-MH-01	1.00	TURN OBJECT OVER USING HOISTTURN AXLE 180 DEG BY HAND		.00445		.005	
0070 E								RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0080 N									1.00	S/U STEADY REST		.13300		.152	
0090 E								RLA-HM-T2	1.00	INSTALL & ADJUST TOOL KDK BAR		.02972		.034	
0100 E								RLA-RC-GA	1.00	RECESS 3-3.5 DIA. 1/8 DP G1 RECENTER		.04385		.050	
0120 E								RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0065			JA	01	15		.05			CHASE THREADS I.D. 2EA ENDS		1.197	.009	.069	3
0010 E								RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0020 E								RLA-HP-C3	2.00	CHUCK SYMET PART IN 4 JAW 2 OCC FOR 2 AXLE ENDS		.09095		.209	
0030 N									1.00	S/U STEADY REST		.13300		.152	
0040 E								RLA-HM-T2	1.00	INSTALL & ADJUST TOOL KDK BAR		.02972		.034	
0050 E								GIG-RH-C3	1.00	CHASE THRDS W/TAP,HSNG LARGECHASE THREADS ON LATHE		.04263		.049	
0060 E								GQH-MH-01	1.00	TURN OBJECT OVER USING HOISTTURN AXLE 180 DEG BY HAND		.00445		.005	
0070 E								RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0080 N									1.00	S/U STEADY REST		.13300		.152	
0090 E								RLA-HM-T2	1.00	INSTALL & ADJUST TOOL KDK BAR		.02972		.034	
0100 E								GIG-RH-C3	1.00	CHASE THRDS W/TAP,HSNG LARGECHASE THREADS ON LATHE		.04263		.049	
0120 E								RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0070			JA	01	15		.40			O/S CROSS BOLT LUGS		1.293	.078	.595	28
0010 E								RHL-SU-V1	1.00	S/U VERT MILL BORE SMAL FXTR		.75732		.870	
0020 E								RHL-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068	
0030 E								RHL-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142	
0040 E								RHL-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0050 E								RHL-BD-AA	1.00	BORE HOLE 1 X 1/2 GROUP 4		.27100		.311	
0070 E								RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0349			JA	01	15		1.00			BUSH CROSS BOLT LUGS		.673	.101	.775	36
0002 E								RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0004 E								RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0008 E								KNL-TB-CC	1.00	DIA .501-1.00 REM .033-.250		.07308		.084	
0060 E								RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0900								THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT							
0901								FOR THIS OPERATION WERE DETERMINED EITHER FROM							
0902								ACTUAL COUNT OR FROM REFERENCE TO T.O. SHOWN ABOVE							
0903								<							
			JA	01	15		1.00			BUSH CROSS BOLT LUGS		.323	.049	.372	18
0010 E								RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517		.212	
0020 E								RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E								RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435		.120	
0040 E								RBW-BU-P1	1.00	BUTTERFLY POLISH BUSHING I D		.00333		.003	
0060 E								RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	

0900				THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT			
0901				FOR THIS OPERATION WERE DETERMINE:	ON		
0902				ACTUAL COUNT OR FROM REFERENCE TO T.O. SHOWN ABOVE			
0903				<			
9000	JA 01	15	.01		LABOR STANDARD HISTORY	.000	.000 .000
0010				PRIOR HISTORY ON OO-ALC 494 FORM			
0020				24JUN83 NEW OCC. FACTOR STUDY & REMOVE ALL RJPPWR1			
0030				ELEMENTS <OLD STD>	1.11		
0031				27DEC84 2 YR REVIEW W/OCC CHANGES > OLD STD < 1.12			
0032				30JULY85 CHANGED SUB OP TO MATCH 958 NO TIME CHANG			
0899				J.CALDWELL TECH MANEAA			
0900				MANEL CLINTON BENTLEY MRP II 7-3255			

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR  
 <- >:----><--->  
 1234567890123456 ELSE PUT IN END  
 ?

74521A STRUT ASSY C-141 NLG

RCC MNPRA

452-59-3

TECH S S W F PF A/R REV

SUB	T K	# R A FA SUPPORT	CCC	DESCRIPTION	BASE	PFD	STD		
STEP	D L	K C DC ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY P
RA504	S E	JA EA 1	J 84154	.21 PERCENT ENGR 92.8	REPAIR OLEO TRUNNION	405	28.66	6.02	
0001		JA 01	00	.00	PART NUMBER/NSN	.000	.000	.000	
	0010			8340783-10	1620001947597				
	0020			8340783-30	NSL				
0030		JA 01	15	.05	REMOVE BUSHINGS	.485	.004	.028	
	0010 E		RBW-SU-G1	1.00 S/U FOR BENCH WORK GENERAL		.27525		.316	
	0020 E		RHT-BE-L1	1.00 BAKE LARGE PART		.11699		.134	
	0030 E		RLG-RS-K4	2.00 REM LRG BUSHING WITH PULLER 2EA BUSHINGS 4 OD X 4.5 LONG		.04169		.095	
	0050 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0033		JA 01	15	.50	LOCALLY POL ID TRUN REM CORR	.143	.011	.082	
	0010 N			1.00	LOCALLY POLISH ID OF TRUNNIO	.13300		.152	
	0020 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0035		JA 01	15	.50	LOCALLY POLISH TRUNNION END	.143	.011	.082	
	0010 N			1.00	REMOVE CORROSION ID TRUN END	.13300		.152	
	0020 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0040		JA 01	15	1.00	NICK & BURR	.352	.053	.405	
	0010 E		RBW-SU-G1	1.00 S/U FOR BENCH WORK GENERAL		.27525		.316	
	0020 E		RLG-RS-N3	1.00 NICK & BURR MED STRUT PART		.06711		.077	
	0040 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0045		JA 01	15	.50	TRUNNION CENTER HOLE REWORK	1.664	.125	.957	
	0010 E		RML-SU-V2	1.00 S/U VERT MILL BORE LRG FIXTRS/U LUCUS MILL		.80167		.921	
	0020 E		RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
	0030 E		RML-AL-AA	1.00 ALIGN HORIZ AXIS ROD		.06265		.072	
	0040 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD		.12699		.146	
	0050 E		RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD		.07609		.087	
	0060 E		RML-BA-GM	1.00 BORE HOLE 4 X 6 GROUP 1		.42920		.493	
	0070 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0050		JA 01	15	.50	O/S END TRUN SOCKET <LEFT>	1.664	.125	.957	
	0010 E		RML-SU-V2	1.00 S/U VERT MILL BORE LRG FIXTRS/U LUCUS MILL		.80167		.921	
	0020 E		RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
	0030 E		RML-AL-AA	1.00 ALIGN HORIZ AXIS ROD		.06265		.072	
	0040 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD		.12699		.146	
	0050 E		RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD		.07609		.087	
	0060 E		RML-BA-GM	1.00 BORE HOLE 4 X 6 GROUP 1		.42920		.493	
	0080 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0060		JA 01	15	.66	O/S END TRUN SOCKET <RIGHT>	1.664	.165	1.263	
	0010 E		RML-SU-V2	1.00 S/U VERT MILL BORE LRG FIXTRS/U LUCUS MILL		.80167		.921	
	0020 E		RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
	0030 E		RML-AL-AA	1.00 ALIGN HORIZ AXIS ROD		.06265		.072	
	0040 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD		.12699		.146	
	0050 E		RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD		.07609		.087	
	0060 E		RML-BA-GM	1.00 BORE HOLE 4 X 6 GROUP 1		.42920		.493	
	0080 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0070		JA 01	15	.33	O/S CROSS BOLT LUG <SMALL>	.739	.037	.281	
	0010 E		RBW-BU-S1	1.00 SET UP TO REBUSH BOSSES		.18517		.212	
	0020 E		RBW-BU-R2	6.00 REAM WITH LEMPCO REAMER 6 PASSES		.07337		.506	
	0030 E		RBW-BU-C1	1.00 CHAMFER SET OF BUSHING BORES		.10435		.120	
	0050 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
.5		JA 01	15	.33	ROLL BURNISH CROSS BOLT HOLE	.930	.046	.353	
	0010 N			2.00	ROLL BURNISH CROSS BOLT HOLE	.46000		1.058	
	0020 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0080		JA 01	15	.17	O/S CROSS BOLT LUG <LARGE>	.666	.017	.130	
	0010 E		RBW-BU-S1	1.00 SET UP TO REBUSH BOSSES		.18517		.212	

0020 E	RBW-BU-R2	5.00	REAM WITH LEMPCO REAMER	6 PASSES	.07337	.421	
0030 E	RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435	.120	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
JA 01	15	.17		ROLL BURNISH LG CRS BOLT HOL	.930	.024	.182
0010 N		2.00		ROLL BURNISH LRG CR BOLT HOL	.46000		1.058
0020 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0090	JA 01	15	.05	O/S MOUNT FLANGE LUG <FWD>	.739	.006	.043
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517		.212
0020 E	RBW-BU-R2	6.00	REAM WITH LEMPCO REAMER	6 PASSES	.07337		.506
0030 E	RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435		.120
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0095	JA 01	15	.05	ROLL BURNISH FWD MOUNTING	.930	.007	.053
0010 N		2.00		BURNISH MTN FLANGES BOLT HOL	.46000		1.058
0020 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0100	JA 01	15	.05	O/S MOUNT FLANGE LUG <AFT>	.739	.006	.043
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517		.212
0020 E	RBW-BU-R2	6.00	REAM WITH LEMPCO REAMER	6 PASSES	.07337		.506
0030 E	RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435		.120
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0105	JA 01	15	.05	ROLL BURNISH AFT MOUNTING FL	.930	.007	.053
0010 N		2.00		BURNISH AFT FLANGE BOLT HOLE	.46000		1.058
0020 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0110	JA 01	15	.05	O/S AFT DOOR LEVER LUG<RIGHT	.666	.005	.038
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517		.212
0020 E	RBW-BU-R2	5.00	REAM WITH LEMPCO REAMER	5 PASSES	.07337		.421
0030 E	RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435		.120
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
115	JA 01	15	.05	ROLL BURNISH AFT DOOR LEVER	.930	.007	.053
0010 N		2.00		BURNISH RS AFT DOOR LUG HOLE	.46000		1.058
0020 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0120	JA 01	15	.05	O/S AFT DOOR LEVER LUG	.666	.005	.038
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517		.212
0020 E	RBW-BU-R2	5.00	REAM WITH LEMPCO REAMER	5 PASSES	.07337		.421
0030 E	RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435		.120
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0125	JA 01	15	.05	ROLL BURNISH LS AFT DOOR LEV	.936	.007	.054
0010 N		2.00		BURNISH LS AFT DOOR LUG HOLE	.46000		1.058
0020 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0135 N		.05		ROLL BURNISH FWD DOOR LEVER	.13000		.007
0130	JA 01	15	.05	O/S FWD DOOR LEVER LUG<RIGHT	.666	.005	.038
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517		.212
0020 E	RBW-BU-R2	5.00	REAM WITH LEMPCO REAMER	5 PASSES	.07337		.421
0030 E	RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435		.120
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0135	JA 01	15	.05	ROLL BURNISH FWD DOOR LEVER	.930	.007	.053
0010 N		2.00		BURNISH FWD RT S DR LEV LUG	.46000		1.058
0020 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0140	JA 01	15	.05	O/S FWD DOOR LEVER LUG<LEFT>	.666	.005	.038
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517		.212
0020 E	RBW-BU-R2	5.00	REAM WITH LEMPCO REAMER	5 PASSES	.07337		.421
0030 E	RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435		.120
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
145	JA 01	15	.05	ROLL BURNISH FWD DOOR LEVER	.930	.007	.053
0010 N		2.00		BURNISH FWD DR LF S LEV LUG	.46000		1.058
0020 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
145	JA 01	15	.05	O/S ACTUATOR LUGS	1.425	.011	.082
0010 E	RML-SU-V2	1.00		S/U LUCUS MILL	.80167		.921
0020 E	RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068
0030 E	RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142
0040 E	RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083

0050 E	RML-BA-AA	2.00	BORE HOLE 1 X 1/2 GROUP 1	2EA LUGS	.17936	.412	
0070 E	RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001	.011	
JA 01	15	1.00		ROLL BURNISH ACTUATOR LUG	.930	.140	1.070 4
J010 N		2.00		ROLL BURNISH ACTUATOR LUG HO	.46000		1.058
0020 E	RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001	.011	
0160	JA 01	15	.33	O/S ATTACH LUG FOR F/SPRAY	1.895	.094	.719 3
0010 E	RML-SU-V2	1.00		S/U LUCUS MILL	.80167	.921	
0020 E	RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917	.068	
0030 E	RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351	.142	
0040 E	RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261	.083	
0050 E	RML-BA-LM	1.50	BORE HOLE 6 X 6 GROUP 1	OCC FOR 6.5 X 9 HOLE	.55232	.952	
0070 E	RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001	.011	
0170	JA 01	15	.17	O/S ATTACH LUG FOR BUSHINGS	1.895	.048	.371 1
0010 E	RML-SU-V2	1.00		S/U LUCUS MILL	.80167	.921	
0020 E	RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917	.068	
0030 E	RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351	.142	
0040 E	RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261	.083	
0050 E	RML-BA-LM	1.50	BORE HOLE 6 X 6 GROUP 1	OCC FOR 6.5 X 9 HOLE	.55232	.952	
0070 E	RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001	.011	
0250	JA 01	15	.33	MACH CENTER ATT LUG F/SPRAY	1.895	.094	.719 3
0010 E	RML-SU-V2	1.00	S/U VERT MILL BORE LRG FIXTRS/U LUCUS MILL		.80167	.921	
0020 E	RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917	.068	
0030 E	RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351	.142	
0040 E	RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261	.083	
0050 E	RML-BA-LM	1.50	BORE HOLE 6 X 6 GROUP 1	OCC FOR 6.5 X 9 FLAME SPRAY	.55232	.952	
0070 E	RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001	.011	
0273	JA 01	15	.17	MACH BUSH CENTER ATTACH LUG	.825	.021	.161 1
0001 E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962	.574	
0002 E	RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095	.104	
0004 E	KML-TA-JC	1.00	DIA 5.00-6.00 REM .033-.250		.09193	.105	
0005 E	KML-TA-JD	5.00	DIA 6.0 REM .250 ADD INCH	OCC FOR 5 ADD. INCHES	.02665	.153	
0070 E	RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001	.011	
0275	JA 01	15	.17	INSTALL BUSH CENTR ATTCH LUG	.217	.006	.342 0
0003 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18669	.214	
0008 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062	.023	
0070 E	RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001	.011	
0276	JA 01	15	.17	FINISH MACH CENTER BUSHING	1.895	.048	.371 1
0010 E	RML-SU-V2	1.00	S/U VERT MILL BORE LRG FIXTR		.80167	.921	
0020 E	RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917	.068	
0030 E	RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351	.142	
0040 E	RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261	.083	
0050 E	RML-BA-LM	1.50	BORE HOLE 6 X 6 GROUP 1	OCC FOR 6.5 X 9 BUSHING	.55232	.952	
0070 E	RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001	.011	
0279	JA 01	15	1.00	MACH BUSH END TRUN SOCKET RT	1.092	.164	1.257 4
0001 E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962	.574	
0002 E	RLA-HP-C3	2.00	CHUCK SYMET PART IN 4 JAW		.09095	.209	
0004 E	KML-TB-GC	1.00	DIA .501-1.00 REM .501-1.00		.13163	.151	
0005 E	KML-TB-GD	5.00	DIA 4.0 REM .250 ADD INCH	OCC FOR 5 ADD. INCHES	.05396	.310	
0120 E	RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001	.011	
0280	JA 01	15	1.00	INSTALL BUSH END TRUN SOC RT	.217	.033	.250 1
0005 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18669	.214	
0008 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062	.023	
0120 E	RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001	.011	
0285	JA 01	15	1.00	FINISH BUSH ID END TRUN SOCK	.288	.043	.332 1
0010 E	RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525	.316	
0020 E	RBW-BU-P1	1.00	BUTTERFLY POLISH BUSHING I D		.00333	.003	
0120 E	RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001	.011	
0289	JA 01	15	1.00	MACH BUSH END TRUN SOCKET LF	1.092	.164	1.257 4
0001 E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962	.574	
0002 E	RLA-HP-C3	2.00	CHUCK SYMET PART IN 4 JAW		.09095	.209	

0004 E	KML-TB-GC	1.00 DIA .501-1.00 REM .501-1.00	.13163	.151	
0005 E	KML-TB-GD	5.00 DIA 4.0 REM .250 ADD INCH OCC FOR 5 ADD. INCHES	.05396	.310	
0120 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0000 JA 01	15	1.00 INSTAL BUSH END TRUN SOCK LF	.217	.033	.250 1
0005 E	RBW-BU-S1	1.00 SET UP TO REBUSH BOSSES	.18669	.214	
0008 E	RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0120 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0295 JA 01	15	1.00 FINISH BUSH ID E TRUN SOC LF	.376	.056	.433 2
0010 E	RBW-SU-G1	1.00 S/U FOR BENCH WORK GENERAL	.27525	.316	
0015 E	KML-RE-MB	2.00 REAM HOLE 1/2-1 5/8 DIA 1	.04377	.100	
0020 E	RBW-BU-P1	1.00 BUTTERFLY POLISH BUSHING I D	.00333	.003	
0120 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0298 JA 01	15	1.00 MACH BUSH CROSS BOLT LUG 2SM	.825	.124	.949 3
0002 E	RLA-SU-S3	1.00 SET UP SMALL MEDIUM LATHE	.49962	.574	
0004 E	RLA-HP-C3	2.00 CHUCK SYMET PART IN 4 JAW 2EA BUSHINGS	.09095	.209	
0008 E	KML-TB-BC	2.00 DIA .251-.500 REM .033-.250 2EA BUSHINGS	.06699	.154	
0050 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0300 JA 01	15	1.00 INSTAL BUSH CROSS BOLT LUG S	.948	.142	1.091 4
0010 E	RBW-BU-S1	1.00 SET UP TO REBUSH BOSSES	.18517	.212	
0020 E	RBW-BU-B2	1.00 REBUSH A SET OF 2 BOSSES	.22231	.255	
0030 E	RBW-BU-C1	2.00 CHAMFER SET OF BUSHING BORES	.10435	.240	
0040 E	KTL-RM-B2	5.00 REAM BUSHING W ADJUST LEMPCO	.06442	.370	
0050 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0305 JA 01	15	1.00 MACH BUSH CROSS BOLT LUG LRG	.837	.126	.963 3
0002 E	RLA-SU-S3	1.00 SET UP SMALL MEDIUM LATHE	.49962	.574	
0004 E	RLA-HP-C3	2.00 CHUCK SYMET PART IN 4 JAW 2EA BUSHINGS	.09095	.209	
0008 E	KML-TB-CC	2.00 DIA .501-1.00 REM .033-.250 2EA BUSHINGS	.07308	.168	
0050 L	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0000 JA 01	15	1.00 INSTAL BUSH CROSS BOLT LUG L	.755	.113	.868 3
0010 E	RBW-BU-S1	1.00 SET UP TO REBUSH BOSSES	.18517	.212	
0020 E	RBW-BU-B2	1.00 REBUSH A SET OF 2 BOSSES	.22231	.255	
0030 E	RBW-BU-C1	2.00 CHAMFER SET OF BUSHING BORES	.10435	.240	
0040 E	KTL-RM-B2	2.00 REAM BUSHING W ADJUST LEMPCO	.06442	.148	
0050 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0315 JA 01	15	1.00 MACH BUSH MOUNT FLANGE FWLUG	.837	.126	.963 3
0002 E	RLA-SU-S3	1.00 SET UP SMALL MEDIUM LATHE	.49962	.574	
0004 E	RLA-HP-C3	2.00 CHUCK SYMET PART IN 4 JAW 2EA BUSHINGS	.09095	.209	
0008 E	KML-TB-CC	2.00 DIA .501-1.00 REM .033-.250 2EA BUSHINGS	.07308	.168	
0050 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0320 JA 01	15	1.00 INSTAL BUSH MONT FLGE LUG FW	.290	.044	.335 1
0001 E	RBW-BU-S1	1.00 SET UP TO REBUSH BOSSES	.18669	.214	
0002 E	KML-RE-MB	2.00 REAM HOLE 1/2-1 5/8 DIA 1	.04377	.100	
0004 E	RBW-BU-P1	2.00 BUTTERFLY POLISH BUSHING I D	.00333	.007	
0050 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0325 JA 01	15	1.00 MACH BUSH MNT FLGE LUG AFT	.837	.126	.963 3
0002 E	RLA-SU-S3	1.00 SET UP SMALL MEDIUM LATHE	.49962	.574	
0004 E	RLA-HP-C3	2.00 CHUCK SYMET PART IN 4 JAW 2EA BUSHINGS	.09095	.209	
0008 E	KML-TB-CC	2.00 DIA .501-1.00 REM .033-.250 2EA BUSHINGS	.07308	.168	
0050 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0330 JA 01	15	1.00 INSTAL BUSH MNT FLGE LUG AFT	.713	.107	.821 3
0010 E	RBW-BU-S1	1.00 SET UP TO REBUSH BOSSES	.18517	.212	
0020 E	RBW-BU-B2	1.00 REBUSH A SET OF 2 BOSSES	.22231	.255	
0030 E	RBW-BU-C1	2.00 CHAMFER SET OF BUSHING BORES	.10435	.240	
0040 E	KML-RE-MB	2.00 REAM HOLE 1/2-1 5/8 DIA 1	.04377	.100	
0050 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0335 JA 01	15	1.00 MACH BUSH AFT DOR LEVER LUG	.837	.126	.963 3
0002 E	RLA-SU-S3	1.00 SET UP SMALL MEDIUM LATHE	.49962	.574	
0004 E	RLA-HP-C3	2.00 CHUCK SYMET PART IN 4 JAW 2EA BUSHINGS	.09095	.209	
0008 E	KML-TB-CC	2.00 DIA .501-1.00 REM .033-.250 2EA BUSHINGS	.07308	.168	
0050 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011	

0340	JA 01	15	1.00	INSTAL BUSH AFT DOR LEVR LUG	.720	.108	.828	3
0010 E		RBW-BU-S1	1.00 SET UP TO REBUSH BOSSES		.18517		.212	
0020 E		RBW-BU-B2	1.00 REBUSH A SET OF 2 BOSSES		.22231		.255	
0030 E		RBW-BU-C1	2.00 CHAMFER SET OF BUSHING BORES		.10435		.240	
0040 E		KML-RE-MB	2.00 REAM HOLE 1/2-1 5/8 DIA 1		.04377		.100	
0045 E		RBW-BU-P1	2.00 BUTTERFLY POLISH BUSHING I D		.00333		.007	
0050 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0345	JA 01	15	1.00	MACH AFT DOOR LEVER LUG BUSH	.837	.126	.963	3
0002 E		RLA-SU-S3	1.00 SET UP SMALL MEDIUM LATHE		.49962		.574	
0004 E		RLA-HP-C3	2.00 CHUCK SYMET PART IN 4 JAW 2EA BUSHINGS		.09095		.209	
0008 E		KML-TB-CC	2.00 DIA .501-1.00 REM .033-.250 2EA BUSHINGS		.07308		.168	
0050 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0350	JA 01	15	1.00	INSTAL BUSH AFT DOR LEVR LUG	.720	.108	.828	3
0010 E		RBW-BU-S1	1.00 SET UP TO REBUSH BOSSES		.18517		.212	
0020 E		RBW-BU-B2	1.00 REBUSH A SET OF 2 BOSSES		.22231		.255	
0030 E		RBW-BU-C1	2.00 CHAMFER SET OF BUSHING BORES		.10435		.240	
0040 E		KML-RE-MB	2.00 REAM HOLE 1/2-1 5/8 DIA 1		.04377		.100	
0045 E		RBW-BU-P1	2.00 BUTTERFLY POLISH BUSHING I D		.00333		.007	
0050 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0355	JA 01	15	1.00	MACH FWD DOOR LEVER LUG BUSH	.837	.126	.963	3
0002 E		RLA-SU-S3	1.00 SET UP SMALL MEDIUM LATHE		.49962		.574	
0004 E		RLA-HP-C3	2.00 CHUCK SYMET PART IN 4 JAW 2EA BUSHINGS		.09095		.209	
0008 E		KML-TB-CC	2.00 DIA .501-1.00 REM .033-.250 2EA BUSHINGS		.07308		.168	
0050 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0360	JA 01	15	1.00	INSTAL BUSH FWD DOR LEVR LUG	.761	.114	.876	3
0010 E		RBW-BU-S1	1.00 SET UP TO REBUSH BOSSES		.18517		.212	
0020 E		RBW-BU-B2	1.00 REBUSH A SET OF 2 BOSSES		.22231		.255	
0030 E		RBW-BU-C1	2.00 CHAMFER SET OF BUSHING BORES		.10435		.240	
0040 E		KTL-RH-B2	2.00 REAM BUSHING W ADJUST LEMPCO		.06442		.148	
0045 E		RBW-BU-P1	2.00 BUTTERFLY POLISH BUSHING I D		.00333		.007	
0050 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0365	JA 01	15	1.00	MACH BUSH FWD DOOR LEVER LUG	.837	.126	.963	3
0002 E		RLA-SU-S3	1.00 SET UP SMALL MEDIUM LATHE		.49962		.574	
0004 E		RLA-HP-C3	2.00 CHUCK SYMET PART IN 4 JAW 2EA BUSHINGS		.09095		.209	
0008 E		KML-TB-CC	2.00 DIA .501-1.00 REM .033-.250 2EA BUSHINGS		.07308		.168	
0050 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0370	JA 01	15	1.00	INSTAL BUSH FWD DOR LEVR LUG	.632	.095	.728	3
0010 E		RBW-BU-S1	1.00 SET UP TO REBUSH BOSSES		.18517		.212	
0020 E		RBW-BU-B2	1.00 REBUSH A SET OF 2 BOSSES		.22231		.255	
0030 E		RBW-BU-C1	2.00 CHAMFER SET OF BUSHING BORES		.10435		.240	
0040 E		RBW-BU-P1	2.00 BUTTERFLY POLISH BUSHING I D		.00333		.007	
0050 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0375	JA 01	15	1.00	MACH BUSH ACTUATOR LUGS	.825	.124	.949	3
0001 E		RLA-SU-S3	1.00 SET UP SMALL MEDIUM		.49962		.574	
0002 E		RLA-HP-C3	2.00 CHUCK SYMET PART IN 2EA BUSHINGS		.09095		.209	
0004 E		KML-TA-CC	2.00 DIA .501-1.00 REM .033-.250 2EA BUSHINGS		.06699		.154	
0070 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0380	JA 01	15	1.00	INSTALL BUSH ACTUATOR LUGS	.254	.038	.293	1
0001 E		RBW-BU-S1	1.00 SET UP TO REBUSH BOSSES		.18669		.214	
0005 E		RBW-BU-A1	1.00 INSTALL SET FLANGED BUSHINGS		.05133		.059	
0010 E		RBW-BU-P1	2.00 BUTTERFLY POLISH BUSHING I D		.00333		.007	
0070 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0390	JA 01	15	1.00	REIDENTIFY	.665	.100	.766	3
0010 E		RBW-SU-G1	1.00 S/U FOR BENCH WORK GENERAL		.27525		.316	
0020 E		KID-MS-01	1.00 METAL STAMP 1ST DIGIT		.00326		.003	
0025 E		AID-SH-01	12.00 METAL STAMP MOD PLATE		.03145		.434	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
9000	JA 01	15	.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010				PRIOR HISTORY ON OO-ALC 494 FORM				
0020				24JUN83 NEW OCC. FACTOR STUDY & REMOVE ALL RJPWR1				

0030  
0031  
032  
0899  
0900

ELEMENTS <OLD STD> 30.59  
27DEC84 2 YR REVIEW W/OCC CHANGE > OLD STD < 22.52  
30JULY85 CHANGED SUB OP TO MATCH 958 NO TIME CHANG  
J.CALDWELL TECH MANEAA  
MANEL CLINTON BENTLEY MRP II 7-3255

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PSD NROP NR

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# LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

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74521A STRUT ASSY C-141 NLG

RCC MNRA

452-59-3

TECH S S W F FF A/R REV

SUB T K #R A FA SUPPORT OCC <----- DESCRIPTION -----> BASE PFD STD A  
STEP D L K C DC ELEMENT FACT STORED SUPPLEMENTAL HOURS TIME HOURS DLY PCT C

RA510	S	E	JA	EA	1	J	84154	.29	PERCENT ENGR 99.9	REPAIR LOWER BEARING	405	2.03		.59	
0001			JA	01	00			.00		PART NUMBER/NSN		.000	.000	.000	0
									3661226-101	1620001257860					
									115689A						
0030			JA	01	15			.13		MACH TO REMOVE FLAME SPRAY		1.489	.029	.223	11
0005	E					RLA-SU-S3		1.00	SET UP SMALL MEDIUM LATHE			.49962		.574	
0010	E					RLA-HP-C3		1.00	CHUCK SYMET PART IN 4 JAW			.09095		.104	
0020	E					RLA-HM-T1		1.00	CHANGE TOOL QUICK CHANGE HLD			.00379		.004	
0030	E					RLA-HM-T2		1.00	INSTALL & ADJUST TOOL KDK BAR			.02972		.034	
0040	E					RLA-HM-F1		1.00	CHANGE FEED			.00326		.003	
0050	E					RLA-BO-LA		1.00	BORE HOLE 5 - 5 1/2 DIA 1 DPBORE I.D.			.24214		.278	
0060	E					RLA-BO-LB		5.00	BORE HOLE 5-5.5 DIA. ADD IN OVER 5 INCHES LONG			.12191		.700	
0080	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0060			JA	01	15			.38		MACH TO CLEANUP I.D.		1.001	.057	.438	21
0010	E					RLA-SU-S3		1.00	SET UP SMALL MEDIUM LATHE			.49962		.574	
0020	E					RLA-HP-C3		1.00	CHUCK SYMET PART IN 4 JAW			.09095		.104	
0030	E					RLA-HM-T1		1.00	CHANGE TOOL QUICK CHANGE HLD			.00379		.004	
0040	E					RLA-HM-T2		1.00	INSTALL & ADJUST TOOL KDK BAR			.02972		.034	
0050	E					RLA-HM-F1		1.00	CHANGE FEED			.00326		.003	
0060	E					RLA-BO-LA		1.00	BORE HOLE 5 - 5 1/2 DIA 1 DP			.24214		.278	
0070	E					RLA-BO-LB		1.00	BORE HOLE 5-5.5 DIA. ADD IN			.12191		.140	
0090	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
J			JA	01	15			1.00		MACH AFTER FLAME SPRAY		1.197	.180	1.378	68
0010	E					RLA-SU-S3		1.00	SET UP SMALL MEDIUM LATHE			.49962		.574	
0020	E					RLA-HP-C3		1.00	CHUCK SYMET PART IN 4 JAW			.09095		.104	
0030	E					RLA-HM-T1		1.00	CHANGE TOOL QUICK CHANGE HLD			.00379		.004	
0040	E					RLA-HM-T2		1.00	INSTALL & ADJUST TOOL KDK BAR			.02972		.034	
0050	E					RLA-HM-F1		1.00	CHANGE FEED			.00326		.003	
0060	E					RLA-BO-LA		1.00	BORE HOLE 5 - 5 1/2 DIA 1 DP			.24214		.278	
0070	E					RLA-BO-LB		1.00	BORE HOLE 5-5.5 DIA. ADD IN			.12191		.140	
0080	E					REW-LU-01		1.00	LUBRICATE BEARING LUG ASSY			.19646		.225	
0100	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0900									THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT						
0901									FOR THIS OPERATION WERE DETERMINED EITHER FROM						
0902									ACTUAL COUNT OR FROM REFERENCE TO T.O. SHOWN ABOVE						
0903									<						
9000			JA	01	15			.01		LABOR STANDARD HISTORY		.000	.000	.000	0
0010									PRIOR HISTORY ON 00-ALC 494 FORM						
0020									24JUN83 NEW OCC. FACTOR STUDY & REMOVE ALL RJPWF1						
0030									ELEMENTS <OLD STD> .40						
0031									27DEC84 2 YR REVIEW W/OCC CHANGE < OLD STD > .43						
0032									29JULY85 CHANGED SUB OP TO MATCH 958 NO TIME CHANG						
0899									J.CALDWELL TECH MANEAA						
0900									MANUEL CLINTON BENTLEY MRP II 7-3255						

3ROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

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74521A STRUT ASSY C-141 NLG

RCC MNFRA

4S2-59-3

TECH S S W F PF A/R REV

SUB	T K	#R A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A
STEP	D L	K C	DC	ELEMENT	ACT	STORED	HOURS	TIME	HOURS	DLY PCT C
RA511	S	E	JA	EA 1	J	84154	.% PERCENT ENGR 99.9			
0001		JA	01	00			.00			
0010						3661092-111				
0045		JA	01	15			.05			
0010	E			RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525	.316	
0020	E			RLG-RS-N4	1.00	NICK & BURR SMALL STRUT PART		.04595	.052	
0040	E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0050		JA	01	15			.05			
0020	E			RML-SU-V1	1.00	S/U VERT MILL BORE SMAL FXTR		.75732	.870	
0030	E			RML-HP-CD	1.00	HOIST HANDLE WRAPPED 2 CLAMP		.18155	.208	
0040	E			RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917	.068	
0050	E			RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351	.142	
0060	E			RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261	.083	
0070	E			RML-RD-BB	2.00	BORE HOLE 1.5 X 1 GROUP 4 2 HOLES		.35729	.821	
0090	E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0320		JA	01	15			1.00			
0002	E			RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962	.574	
0004	E			RLA-HP-C3	2.00	CHUCK SYMET PART IN 4 JAW 2EA BUSHINGS		.09095	.209	
0050	E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0900						THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT				
0901						FOR THIS OPERATION WERE DETERMINED EITHER FROM				
0902						ACTUAL COUNT OR FROM REFERENCE TO T.O. SHOWN ABOVE				
0903						<				
0325		JA	01	15			1.00			
0006	E			RSG-JP-T1	1.00	JOB PREP GENERAL FOR S & M		.22079	.253	
0008	E			KML-TB-DC	2.00	DIA 1.00-1.50 REM .033-.250 2EA BUSHINGS		.08429	.193	
0010	E			RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517	.212	
0020	E			RBW-BU-B1	2.00	REBUSH A SET OF 2 BOSSES OCC FOR 2EA MEN		.23835	.548	
0030	E			RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435	.120	
0050	E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0900						THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT				
0901						FOR THIS OPERATION WERE DETERMINED EITHER FROM				
0902						ACTUAL COUNT OR FROM REFERENCE TO T.O. SHOWN ABOVE				
0903						<				
9000		JA	01	15			.01			
0010						LABOR STANDARD HISTORY		.000	.000	.000
0020						PRIOR HISTORY ON 00-MLC 494 FORM				
0030						24JUN83 NEW OCC. FACTOR STUDY & REMOVE ALL RJPPWF1				
0031						ELEMENTS <OLD STD> 1.85				
0032						27DEC84 2 YR REVIEW W/OCC CHANGE < OLD STD > 2.12				
0899						29JULY85 CHANGED SUB OP TO MATCH 953 NO TIME CHANG				
0900						J.CALDWELL TECH MANEAM				
						MANEL CLINTON BENTLEY MRP II 7-3255				

INTERROGATE LABOR STANDARDS, INPUT

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

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74521A STRUT ASSY C-141 NLG

RCC MNRA

4S2-59-3

TECH S S W F PF A/R REV

SUB	T K	#R A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A	
STEP	D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
RAS12	S E	JA	EA	1	J 84154	.96 PERCENT ENGR 91.9	REPAIR STEERING PLATE	405	2.78	2.67	
0001		JA	01	00		.00	PART NUMBER/NSN	.000	.000	.000	0
0010						3661027-101	1620000110320				
0040		JA	01	15		.05	O/S ATTACH LUGS	1.819	.014	.105	4
0010 E				RML-SU-V1	1.00	S/U VERT MILL BORE SMAL FXTRS/U JIG BORE SMALL FIXTURE	.75732		.870		
0020 E				RML-AL-CA	2.00	ALIGN HORIZ AXIS MAG BASE 2 HOLES	.05917		.136		
0030 E				RML-AL-CB	2.00	ALIGN VERTICAL AXIS MAG BASE2 HOLES	.12351		.284		
0040 E				RML-AL-CC	2.00	ALIGN HOLE TO SPINDLE MAG BS2 HOLES	.07261		.167		
0045 E				RML-BD-AA	2.00	BORE HOLE 1 X 1/2 GROUP 4 2 HOLES	.27100		.623		
0060 E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011		
0050		JA	01	15		.78	MACH KEYSLOTS	1.570	.184	1.409	51
0010 E				RML-SU-V1	1.00	S/U VERT MILL BORE SMAL FXTR	.75732		.870		
0020 E				RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE	.05917		.068		
0030 E				RML-AL-CB	4.00	ALIGN VERTICAL AXIS MAG BASE	.12351		.568		
0040 N					1.00		MACHINE SLOT	.25000		.287	
0060 E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011		
0170		JA	01	15		.70	MACHINE ATTACH HOLE BUSHINGS	1.058	.111	.852	31
0002 E				RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE	.49962		.574		
0004 E				RLA-HP-C3	2.00	CHUCK SYMET PART IN 4 JAW 2EA BUSHINGS	.09095		.209		
0006 E				RSG-JP-T1	1.00	JOB PREP GENERAL FOR S & M	.22079		.253		
0008 E				KML-TB-CC	2.00	DIA .501-1.00 REM .033-.250 2EA BUSHINGS	.07308		.168		
0060 E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011		
0900							THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT				
0901							FOR THIS OPERATION WERE DETERMINED EITHER FROM				
0902							ACTUAL COUNT OR FROM REFERENCE TO T.O, SHOWN ABOVE				
0903							>				
0175		JA	01	15		.70	BUSH ATTACH LUG HOLES	.521	.055	.420	15
0010 E				RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES	.18517		.212		
0020 E				RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES	.22231		.255		
0030 E				RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES	.10435		.120		
0060 E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011		
9000		JA	01	15		.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010							PRIOR HISTORY ON DD-ALC 494 FORM				
0020							24JUN83 NEW OCC. FACTOR STUDY & REMOVE ALL RJPWF1				
0030							ELEMENTS <OLD STD> 2.48				
0031							27DEC84 2 YR REVIEW W/OCC CHANGE < OLD STD > 3.25				
0899							J.CALDWELL TECH MANEAA				
0900							MANEL CLINTON BENTLEY MRP II 7-3255				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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# LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

01/29/88

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74521A STRUT ASSY C-141 NLG

RCC MNPRA

452-59-3

SUB	TECH S S		W F PF A/R REV		OCC	DESCRIPTION		BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
	STEP	D L	K C	DC ELEMENT		STORED	SUPPLEMENTAL				
RA520	S	E	JA	EA 1	J 87342	1.00 PERCENT ENGR 99.9	REP FILLER TUBE	.78		.78	
0001			JA	01 15		1.00	PART NUMBER/NSN	.000	.000	.000	0
	0010					7530983-01	1620010397401LE				
0030			JA	01 15		1.00	MACH FILLER TUBE FOR STD SIZ	.573	.086	.659	84
	0010	E			RLA-SU-S3	1.00 SET UP SMALL MEDIUM LATHE		.49962		.574	
	0020	E			RLA-TD-DC	1.00 REMOVE .033 -.250 DIA OVER 1		.06341		.072	
	0030	E			RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0040			JA	01 15		1.00	BRUSH CAD PLATE	.105	.016	.121	16
	0020	E			RLG-RS-B1	1.00 BRUSH PLATE SPOT OR HOLE		.09546		.109	
	0030	E			RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
9000			JA	01 00		.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0900							HANEL CLINTON BENTLEY MRP II 7-3255				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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74521A STRUT ASSY C-141 NLG

RCC MNPRA

452-57-3

A-E046B-NM1-DY-M45 PAGE 0001

DATE	TECH	S S	W F	PF	A/R	REV	SUB	T K	# R	A FA	SUPPORT	OCC	DESCRIPTION	BASE	PF	STD	A
	STEP	D L	K C	DC	ELEMENT	FACT						STO	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
RA524	S	E	JA	EA	1	J 87342	1.00	PERCENT ENGR 99.9					CHECK CONCENTRICITY	.33		.33	
0001			JA	01	00	.01		PART NUMBER/MSN					.000	.000	.000	0	
	0010						3661091-103	162008676271									
0045			JA	01	15	1.00							.293	.044	.337	100	
	0010	E			RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL						.27525		.316		
	0020	E			RLG-EI-CC	1.00	CHK CONC IN CNTRNG DEVICE						.00789		.009		
	0030	E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC						.01001		.011		
9000			JA	01	00	1.00		LABOR STANDARD HISTORY					.000	.000	.000	0	
	0900						MANEL CLINTON BENTLEY MRP II	7-3255									

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NEOP NR

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## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

01/29/88

A-E046B-MM1-DY-M45 PAGE 0001

74521A STRUT ASSY C-141 NLG

RCC MNPB

4S2-59-3

TECH S S		W F PF A/R REV		SUB T K		R A FA SUPPORT		OCC <-----		DESCRIPTION <----->		BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
STEP	D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL								
R2501	S	E	JA	EA 3	J	84154	.75	PERCENT ENGR	99.9	OUTER CYL C141 NLG	405	15.77		11.83	
0001			JA	01	00		.00			PART NUMBER/NSN		.000	.000	.000	0
0010								3G61090-119		1620004419763					
0110			JA	01	15		.39			1ST GR TRUN JR/CHROME		2.291	.134	1.028	7
0010 E						RGR-SU-G1	1.00	SET UP A GAP GRINDER				1.05938		1.218	
0020 E						RGR-HP-L1	1.00	LOAD LARGE PART GAP GRINDER				.13653		.157	
0030 E						RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK				.22097		.254	
0040 E						RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER				.02632		.030	
0050 E						RGR-HM-S3	1.00	GAP GRINDER TURN OFF & ON				.00685		.007	
0060 E						RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER				.08334		.095	
0070 E						RGR-GE-S2	54.00	GR STEEL OD (OCC FACT L X D) 9 IN. LONG 6 IN. DIA.				.01093		.678	
0080 E						RGR-GE-D2	6.00	DWELL (GAP GRINDER STEEL OD) 6 IN. DIA.				.01014		.069	
0090 E						RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12				.09717		.111	
0110 E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC				.01001		.011	
0120			JA	01	15		.06			1ST GR TRUN JR/F-SPRAY		2.153	.019	.149	1
0010 E						RGR-SU-G1	.87	SET UP A GAP GRINDER		13 % OCC OCCURED IN 1ST GR		1.05938		1.059	
0011								FOR CHROME S/U							
0020 E						RGR-HP-L1	1.00	LOAD LARGE PART GAP GRINDER				.13653		.157	
0030 E						RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK				.22097		.254	
0040 E						RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER				.02632		.030	
0050 E						RGR-HM-S3	1.00	GAP GRINDER TURN OFF & ON				.00685		.007	
0060 E						RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER				.08334		.095	
0070 E						RGR-GE-S2	54.00	GR STEEL OD (OCC FACT L X D) 9 IN. LONG 6 IN. DIA.				.01093		.678	
0080 E						RGR-GE-D2	6.00	DWELL (GAP GRINDER STEEL OD) 6 IN. DIA.				.01014		.069	
0090 E						RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12				.09717		.111	
0110 E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC				.01001		.011	
0130			JA	01	15		.33			1ST GR COLLAR JR/CHROME		2.029	.100	.770	5
0010 E						RGR-SU-G1	1.00	SET UP A GAP GRINDER				1.05938		1.218	
0020 E						RGR-HP-L1	1.00	LOAD LARGE PART GAP GRINDER				.13653		.157	
0030 E						RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK				.22097		.254	
0040 E						RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER				.02632		.030	
0050 E						RGR-HM-S3	1.00	GAP GRINDER TURN OFF & ON				.00685		.007	
0060 E						RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER				.08334		.095	
0070 E						RGR-GE-S2	30.00	GR STEEL OD (OCC FACT L X D) 5 IN. LONG 6 IN. DIA.				.01093		.377	
0080 E						RGR-GE-D2	6.00	DWELL (GAP GRINDER STEEL OD) 6 IN. DIA.				.01014		.069	
0090 E						RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12				.09717		.111	
0110 E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC				.01001		.011	
0140			JA	01	15		.33			1ST GR COLLAR JR/SPRAY		2.029	.100	.770	5
0010 E						RGR-SU-G1	1.00	SET UP A GAP GRINDER				1.05938		1.218	
0020 E						RGR-HP-L1	1.00	LOAD LARGE PART GAP GRINDER				.13653		.157	
0030 E						RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK				.22097		.254	
0040 E						RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER				.02632		.030	
0050 E						RGR-HM-S3	1.00	GAP GRINDER TURN OFF & ON				.00685		.007	
0060 E						RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER				.08334		.095	
0070 E						RGR-GE-S2	30.00	GR STEEL OD (OCC FACT L X D) 5 IN. LONG 6 IN. DIA.				.01093		.377	
0080 E						RGR-GE-D2	6.00	DWELL (GAP GRINDER STEEL OD) 6 IN. DIA.				.01014		.069	
0090 E						RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12				.09717		.111	
0110 E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC				.01001		.011	
0150			JA	01	15		.44			1ST GRIND UPPER BORE		5.494	.363	2.780	18
0010 E						RGR-SU-G1	1.00	SET UP A GAP GRINDER		S/U INTERNAL GRINDER		1.05938		1.218	
0020 E						RGR-HP-L3	1.00	LOAD EX LRG PRT GAP GR FIXT LOAD/UNLOAD PART HOIST				.36081		.414	
0030 E						RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK				.22097		.254	
0040 E						KMG-DW-ID	1.00	DRESS INTERNAL WHEEL				.02458		.028	

0050 E	KMG-ID-LE	6.00 GRIND OUT .010 5 ID X 3	OCC FOR AREA 18 INCHES LONG	.60998	4.208			
0060 E	RGR-HM-T2	1.00 ADJUST TAPER - GAP GRINDER	ADJUST TAPER INTERNAL GRIND	.02632	.030			
0070 E	RGR-HM-C4	1.00 HANDLE & MEAS LENGTH 12 - 24		.10674	.122			
0080 E	RGR-HM-S3	1.00 GAP GRINDER TURN OFF & ON	INT GRINDER TURN OFF & ON	.00685	.007			
0090 E	RTL-MM-S1	1.00 SET UP INSIDE MICROMETER		.01920	.022			
0110 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001	.011			
0160	JA 01	15	.33	1ST GRIND LOWER BORE	3.477	.172	1.320	8
0010 E	RGR-SU-G1	1.00 SET UP A GAP GRINDER	S/U INTERNAL GRINDER	1.05938	1.218			
0020 E	RGR-HP-L3	1.00 LOAD EX LRG PRT GAP GR FIXT	LOAD/UNLOAD PART/HOIST	.36081	.414			
0030 E	RLA-HP-C4	1.00 IRREG PART IN 4 JAW CHUCK		.22097	.254			
0040 E	KMG-ID-ID	1.00 DRESS INTERNAL WHEEL		.02458	.028			
0050 E	KMG-ID-NE	2.30 GRIND OUT .010 6.0 ID X 3.0	OCC FOR AREA 7 IN. LONG	.71847	1.900			
0060 E	RGR-HM-T2	1.00 ADJUST TAPER - GAP GRINDER	ADJUST TAPER INT. GRINDER	.02632	.030			
0070 E	RGR-HM-C3	1.00 HANDLE & MEAS LENGTH 5 TO 12		.09717	.111			
0080 E	RGR-HM-S3	1.00 GAP GRINDER TURN OFF & ON	TURN OFF & ON INT. GRINDER	.00685	.007			
0090 E	RTL-MM-S1	1.00 SET UP INSIDE MICROMETER		.01920	.022			
0110 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001	.011			
0470	JA 01	15	.06	2ND GR TRUN JR/F-SPRAY	2.291	.021	.158	1
0010 E	RGR-SU-G1	1.00 SET UP A GAP GRINDER		1.05938	1.218			
0020 E	RGR-HP-L1	1.00 LOAD LARGE PART GAP GRINDER		.13653	.157			
0030 E	RLA-HP-C4	1.00 IRREG PART IN 4 JAW CHUCK		.22097	.254			
0040 E	RGR-HM-T2	1.00 ADJUST TAPER - GAP GRINDER		.02632	.030			
0050 E	RGR-HM-S3	1.00 GAP GRINDER TURN OFF & ON		.00685	.007			
0060 E	RGR-WD-G2	1.00 WHEEL DRESS GAP GRINDER		.08334	.095			
0070 E	RGR-GE-S2	54.00 GR STEEL OD (OCC FACT L X D) 9 X 6		.01093	.678			
0080 E	RGR-GE-D2	6.00 DWELL (GAP GRINDER STEEL OD) 6 DIA		.01014	.069			
0090 E	RGR-HM-C3	1.00 HANDLE & MEAS LENGTH 5 TO 12		.09717	.111			
0110 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001	.011			
0470	JA 01	15	.33	2ND GR COLLAR JR/F-SPRAY	2.029	.100	.770	5
0010 E	RGR-SU-G1	1.00 SET UP A GAP GRINDER		1.05938	1.218			
0020 E	RGR-HP-L1	1.00 LOAD LARGE PART GAP GRINDER		.13653	.157			
0030 E	RLA-HP-C4	1.00 IRREG PART IN 4 JAW CHUCK		.22097	.254			
0040 E	RGR-HM-T2	1.00 ADJUST TAPER - GAP GRINDER		.02632	.030			
0050 E	RGR-HM-S3	1.00 GAP GRINDER TURN OFF & ON		.00685	.007			
0060 E	RGR-WD-G2	1.00 WHEEL DRESS GAP GRINDER		.08334	.095			
0070 E	RGR-GE-S2	30.00 GR STEEL OD (OCC FACT L X D) 5 X 6	GRIND FLAME SPRAY	.01093	.377			
0080 E	RGR-GE-D2	6.00 DWELL (GAP GRINDER STEEL OD) 6IN DIA	FLAME SPRAY	.01014	.069			
0090 E	RGR-HM-C3	1.00 HANDLE & MEAS LENGTH 5 TO 12		.09717	.111			
0110 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001	.011			
0490	JA 01	15	.39	2ND GR TRUN JR/CHROME	2.883	.169	1.293	8
0010 E	RGR-SU-G1	1.00 SET UP A GAP GRINDER		1.05938	1.218			
0020 E	RGR-HP-L1	1.00 LOAD LARGE PART GAP GRINDER		.13653	.157			
0030 E	RLA-HP-C4	1.00 IRREG PART IN 4 JAW CHUCK		.22097	.254			
0040 E	RGR-HM-T2	1.00 ADJUST TAPER - GAP GRINDER		.02632	.030			
0050 E	RGR-HM-S3	1.00 GAP GRINDER TURN OFF & ON		.00685	.007			
0060 E	RGR-WD-G2	1.00 WHEEL DRESS GAP GRINDER		.08334	.095			
0070 E	RGR-GE-C2	54.00 GR CHROM OD (OCC FACT L X D) 9 X 6		.02189	1.359			
0080 E	RGR-GE-D2	6.00 DWELL (GAP GRINDER STEEL OD) 6IN DIA		.01014	.069			
0090 E	RGR-HM-C3	1.00 HANDLE & MEAS LENGTH 5 TO 12		.09717	.111			
0110 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001	.011			
0500	JA 01	15	.39	2ND GR COLLAR JR/CHROME	2.358	.138	1.058	7
0010 E	RGR-SU-G1	1.00 SET UP A GAP GRINDER		1.05938	1.218			
0020 E	RGR-HP-L1	1.00 LOAD LARGE PART GAP GRINDER		.13653	.157			
0030 E	RLA-HP-C4	1.00 IRREG PART IN 4 JAW CHUCK		.22097	.254			
0040 E	RGR-HM-T2	1.00 ADJUST TAPER - GAP GRINDER		.02632	.030			
0050 E	RGR-HM-S3	1.00 GAP GRINDER TURN OFF & ON		.00685	.007			
0060 E	RGR-WD-G2	1.00 WHEEL DRESS GAP GRINDER		.08334	.095			
0070 E	RGR-GE-C2	30.00 GR CHROM OD (OCC FACT L X D) 5 X 6		.02189	.755			
0080 E	RGR-GE-D2	6.00 DWELL (GAP GRINDER STEEL OD) 6IN DIA		.01014	.069			
0090 E	RGR-HM-C3	1.00 HANDLE & MEAS LENGTH 5 TO 12		.09717	.111			

0110 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0530 JA 01 15		.44	GRIND CHROME UPPER BORE	8.777	.579	4.441	28
0010 E	RGR-SU-G1	1.00	SET UP A GAP GRINDER S/U INTERNAL GRINDER	1.05938		1.218	
0020 E	RGR-HP-L3	1.00	LOAD EX LRG PRT GAP GR FIXT LOAD/UNLOAD PART/HOIST	.36081		.414	
0030 E	RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK	.22097		.254	
0040 E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER ADJUST TAPER INT.GRINDER	.02632		.030	
0050 E	RGR-HM-S3	1.00	GAP GRINDER TURN OFF & ON TURN OFF & ON INT.GRINDER	.00685		.007	
0060 E	KMG-DW-ID	1.00	DRESS INTERNAL WHEEL	.02458		.028	
0070 E	KMG-ID-LK	6.00	GRIND OUT .040 5 ID X 3 OCC FOR AREA 18 IN.LONG	1.15712		7.984	
0080 E	RTL-MM-S1	1.00	SET UP INSIDE MICROMETER	.01920		.022	
0090 E	RGR-HM-C4	1.00	HANDLE & MEAS LENGTH 12 - 24	.10674		.122	
0110 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0530 JA 01 15		.24	GRIND CHROME LOWER BORE	4.486	.162	1.238	8
0010 E	RGR-SU-G1	1.00	SET UP A GAP GRINDER S/U INTERNAL GRINDER	1.05938		1.218	
0020 E	RGR-HP-L3	1.00	LOAD EX LRG PRT GAP GR FIXT LOAD/UNLOAD PART/HOIST	.36081		.414	
0030 E	RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK	.22097		.254	
0040 E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	.02632		.030	
0050 E	KMG-DW-ID	1.00	DRESS INTERNAL WHEEL	.02458		.028	
0060 E	KMG-ID-LK	2.30	GRIND OUT .040 5 ID X 3 OCC FOR AREA 7IN.LONG	1.15712		3.060	
0070 E	RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12	.09717		.111	
0080 E	RGR-HM-S3	1.00	GAP GRINDER TURN OFF & ON TURN OFF & ON INT GRINDER	.00685		.007	
0090 E	RTL-MM-S1	1.00	SET UP INSIDE MICROMETER	.01920		.022	
0110 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0900			THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT				
0901			FOR THIS OPERATION WERE DETERMINED EITHER FROM				
0902			ACTUAL COUNT OR FROM REFERENCE TO T.O. SHOWN ABOVE				
0903			<				
0900 JA 01 15		.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010			PRIOR HISTORY ON 00-ALC 494 FORM				
0020			27JUN83 NEW OCC. FACTOR STUDY & REMOVE ALL RJPWF1				
0030			ELEMENTS <OLD STD> 6.92				
0031			27DEC84 2 YR REVIEW W/OCC CHANGE > OLD STD < 8.69				
0032			30JULY85 CHANGED SUB OP TO MATCH 958 NO TIME CHANG				
0877			J.CALIWELL TECH MANEAA				
0900			MANEL CLINTON BENTLEY MRP II 7-3255				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

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74521A STRUT ASSY C-141 NLG

RCC MNFRB

4S2-59-3

TECH S S W F PF A/R REV

SUB	T K	#R A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A
STEP	D L	K C	DC	ELEMENT	FACT	STORED	HOURS	TIME	HOURS	DLY PCT C
RB502	S	N	JA	EA 3	J 84194	.50 PERCENT ENGR 79.1	5.03		2.51	
0001			JA	01 00		GRIND INNER CYL C141 NLG 407	.000	.000	.000	0
	0010					PART NUMBER/NSM				
						3G61089-111 1620004983226				
0110			JA	01 15		1ST GRIND CYL. O.D.	3.076	.162	1.238	25
	0010 E				RGR-SU-G1	1.00 SET UP A GAP GRINDER	1.05938		1.218	
	0015 E				RGR-HP-L3	1.00 LOAD EX LRG PRT GAP GR FIXT	.36081		.414	
	0020 E				RLA-HP-C4	1.00 IRREG PART IN 4 JAW CHUCK	.22097		.254	
	0030 E				RGR-HM-T2	1.00 ADJUST TAPER - GAP GRINDER	.02632		.030	
	0040 E				RGR-HM-H1	1.00 ADJUST HEADSTOCK GAP GRINDER	.08590		.098	
	0050 E				RGR-HM-S3	1.00 GAP GRINDER TURN OFF & ON	.00685		.007	
	0060 E				RGR-WD-G2	1.00 WHEEL DRESS GAP GRINDER	.08334		.095	
	0070 E				RGR-GE-S2	97.50 GR STEEL OD (OCC FACT L X D) 19.5 X 5. IN DIA.	.01093		1.225	
	0080 E				RGR-GE-D2	5.00 DWELL (GAP GRINDER STEEL OD) 5. IN DIA.	.01014		.058	
	0090 E				RGR-HM-C4	1.00 HANDLE & MEAS LENGTH 12 - 24	.10674		.122	
	0110 E				RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0120			JA	01 15		1ST GRIND UPPER END O.D.	2.041	.015	.117	2
	0010 E				RGR-SU-G1	1.00 SET UP A GAP GRINDER	1.05938		1.218	
	0015 E				RGR-HP-L3	1.00 LOAD EX LRG PRT GAP GR FIXT	.36081		.414	
	0020 E				RLA-HP-C4	1.00 IRREG PART IN 4 JAW CHUCK	.22097		.254	
	0030 E				RGR-HM-T2	1.00 ADJUST TAPER - GAP GRINDER	.02632		.030	
	0040 E				RGR-HM-S3	1.00 GAP GRINDER TURN OFF & ON	.00685		.007	
	0050 E				RGR-WD-G2	1.00 WHEEL DRESS GAP GRINDER	.08334		.095	
	0060 E				RGR-GE-S2	13.50 GR STEEL OD (OCC FACT L X D) 3 X 4.5	.01093		.169	
	0070 E				RGR-GE-D2	4.50 DWELL (GAP GRINDER STEEL OD) 4.5 DIA	.01014		.052	
	0080 E				RGR-HM-C2	1.00 HANDLE & MEAS LENGTH 1 TO 5	.08102		.093	
	0100 E				RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0125			JA	01 15		HONE METERING PIN SEAL AREA	.566	.014	.111	2
	0010 E				RBW-SU-G1	1.00 S/U FOR BENCH WORK GENERAL	.27525		.316	
	0020 E				RLG-HP-V7	1.00 OBJ IN/OUT STP VISE-HST HAND	.06831		.078	
	0030 E				ZPO-BP-C3	1.00 BUTTERFLY POLISH LRG CYL I.D	.21256		.244	
	0040 E				RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0130			JA	01 15		1ST GRIND SEAL AREA H/PIN ID	2.015	.024	.185	4
	0010 E				RGR-SU-G1	1.00 SET UP A GAP GRINDER	1.05938		1.218	
	0020 E				RGR-HP-L3	1.00 LOAD EX LRG PRT GAP GR FIXT	.36081		.414	
	0030 E				RGR-HM-T2	1.00 ADJUST TAPER - GAP GRINDER	.02632		.030	
	0040 E				KMG-DW-ID	2.00 DRESS INTERNAL WHEEL	.02458		.056	
	0050 E				KMG-GW-LK	2.00 LOCATE WHEEL TO POSITION	.06761		.155	
	0060 E				KMG-ID-KC	1.00 GRIND OUT .010 ID X 1.5	.29382		.337	
	0070 E				RGR-HM-C2	1.00 HANDLE & MEAS LENGTH 1 TO 5	.08102		.093	
	0090 E				RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0260			JA	01 15		GRIND CHROME CYL O.D.	4.145	.205	1.573	31
	0010 E				RGR-SU-G1	1.00 SET UP A GAP GRINDER	1.05938		1.218	
	0015 E				RGR-HP-L3	1.00 LOAD EX LRG PRT GAP GR FIXT	.36081		.414	
	0020 E				RLA-HP-C4	1.00 IRREG PART IN 4 JAW CHUCK	.22097		.254	
	0030 E				RGR-HM-T2	1.00 ADJUST TAPER - GAP GRINDER	.02632		.030	
	0040 E				RGR-HM-H1	1.00 ADJUST HEADSTOCK GAP GRINDER	.08590		.098	
	0050 E				RGR-HM-S3	1.00 GAP GRINDER TURN OFF & ON	.00685		.007	
	0060 E				RGR-WD-G2	1.00 WHEEL DRESS GAP GRINDER	.08334		.095	
	0070 E				RGR-GE-C2	97.50 GR CHROM OD (OCC FACT L X D) 19.5 X 5 INCH DIA	.02189		2.454	
	0080 E				RGR-GE-D2	5.00 DWELL (GAP GRINDER STEEL OD) 5. IN. DIA.	.01014		.058	
	0090 E				RGR-HM-C4	1.00 HANDLE & MEAS LENGTH 12 - 24	.10674		.122	
	0110 E				RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0270			JA	01 15		GRIND CHROME UPPER END O.D	2.235	.017	.129	3

0010 E	RGR-SU-G1	1.00 SET UP A GAP GRINDER	1.05938	1.218	
0015 E	RGR-HP-L3	1.00 LOAD EX LRG PRT GAP GR FIXT	.36081	.414	
0020 E	RLA-HP-C4	1.00 IRREG PART IN 4 JAW CHUCK	.22097	.254	
0030 E	RGR-HM-T2	1.00 ADJUST TAPER - GAP GRINDER	.02632	.030	
0040 E	RGR-HM-S3	1.00 GAP GRINDER TURN OFF & ON	.00685	.007	
0050 E	RGR-WD-G2	1.00 WHEEL DRESS GAP GRINDER	.08334	.095	
0060 E	RGR-GE-C2	13.50 GR CHROM OD (OCC FACT L X D) 3 X 4.5	.02189	.339	
0070 E	RGR-GE-D3	4.50 DWELL (GAP GRINDER CHROM OD) 4.5 DIA	.02029	.105	
0080 E	RGR-HM-C2	1.00 HANDLE & MEAS LENGTH 1 TO 5	.08102	.093	
0100 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0280	JA 01	15 .08 GRIND CHROME SEAL AREA M/PIN	2.320	.028	4
0010 E	RGR-SU-G1	1.00 SET UP A GAP GRINDER S/U INTERNAL GRINDER	1.05938	1.218	
0020 E	RGR-HP-L3	1.00 LOAD EX LRG PRT GAP GR FIXT LOAD EX LARGE PART INT GRIND	.36081	.414	
0030 E	RGR-HM-T2	1.00 ADJUST TAPER - GAP GRINDER	.02632	.030	
0040 E	KMG-DW-ID	2.00 DRESS INTERNAL WHEEL OCC FOR ROUGH & FINISH GRIND	.02458	.056	
0050 E	KMG-GW-LK	2.00 LOCATE WHEEL TO POSITION OCC FOR ROUGH & FINISH GRIND	.06761	.155	
0060 E	KMG-ID-KH	1.00 GRIND OUT .040 4.5 ID X 1.5	.59881	.688	
0070 E	RGR-HM-C2	1.00 HANDLE & MEAS LENGTH 1 TO 5	.08102	.093	
0090 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0358	JA 01	15 .25 HONE AXLE ATT. LUG F/SPRAY	1.538	.058	9
0010 E	RDR-SU-V1	1.00 S-U DR PRS W-VISE FIXT DV-HDS/U TO HONE	.42803	.492	
0020 N		1.00 HONE AXLE ATTACH LUG	1.10000	1.265	
0040 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0430	JA 01	15 .58 HONE AXLE ATTACH LUG	1.538	.134	20
0010 E	RDR-SU-V1	1.00 S-U DR PRS W-VISE FIXT DV-HDS/U TO HONE	.42803	.492	
0020 N		1.00 HONE AXLE ATTACH LUG	1.10000	1.265	
0030 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0000	JA 01	15 .01 LABOR STANDARD HISTORY	.000	.000	0
0010		PRIOR HISTORY ON 00-ALC 494 FORM			
0020		27JUN83 NEW OCC FACTOR STUDY & REMOVE ALL RJPPWF1			
0030		ELEMENTS <OLD STD> 3.77			
0040		26JUL83 NEW SUB OP.0055-OCC. EST <OLD STD> 3.25			
0050		25JAN84 ADD SUB OP 0000-EST OCC- <OLD STD> 3.28			
0051		27DEC84 2 YR REVIEW W/OCC CHANGE > OLD STD < 3.47			
0052		30JULY85 CHANGED SUB OP TO MATCH 958 NO TIME CHANG			
0899		J.CALDWELL TECH MANEAA			
0900		HANEL CLINTON BENTLEY MRP II 7-3255			

TO INTERROGATE LABOR STANDARDS, INPUT

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SUB	TECH S S	T K	W F PF A/R REV	TR A FA SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A
STEP D L	K C DC ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C		
RR503	S E JA EA 3	J 84154	.33	PERCENT ENGR 99.9	GRIND AXLE C141 NLG	405	.03	1.33		
0001	JA 01 00	.00		PART NUMBER/NSN	.000	.000	.000	0		
0010				3G61032-107	1620009272599					
0110	JA 01 15	.75		1ST GRIND CENTER JOURNAL	1.357	.153	1.171	29		
0010 E	RGR-SU-P1	1.00	SET UP PLANETARY GRINDER	S/U SM/MED CYL GRINDER	.82175		.945			
0015 E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER CYL GRINDER	.02632		.030			
0020 E	KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02308		.053			
0030 E	KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155			
0040 E	RGR-GE-S2	18.00	GR STEEL OD (OCC FACT L X D) 1.5 X 4 X 3EA JOURNALS		.01093		.226			
0050 E	RGR-GE-D2	4.00	DWELL (GAP GRINDER STEEL OD) DWELL CYL GRINDER OCC X OD		.01014		.046			
0060 E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093			
0080 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011			
0120	JA 01 15	.25		1ST GRIND LARGE JOURNALS	1.335	.050	.384	10		
0010 E	RGR-SU-P1	1.00	SET UP PLANETARY GRINDER	S/U SM/MED CYL GRINDER	.82175		.945			
0015 E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER CYL GRINDER	.02632		.030			
0020 E	KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02308		.053			
0030 E	KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155			
0040 E	RGR-GE-S2	16.00	GR STEEL OD (OCC FACT L X D) 2 X 4 X 2EA JOURNALS		.01093		.201			
0050 E	RGR-GE-D2	4.00	DWELL (GAP GRINDER STEEL OD) DWELL CYL GRINDER OCC X OD		.01014		.046			
0060 E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093			
0080 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011			
0	JA 01 15	.13		1ST GRIND SMALL JOURNALS	1.292	.025	.193	5		
0010 E	RGR-SU-P1	1.00	SET UP PLANETARY GRINDER	S/U SM/MED CYL GRINDER	.82175		.945			
0015 E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER CYL GRINDER	.02632		.030			
0020 E	KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02308		.053			
0030 E	KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155			
0040 E	RGR-GE-S2	12.00	GR STEEL OD (OCC FACT L X D) 1.5 X 4 X 2EA JOURNALS		.01093		.150			
0050 E	RGR-GE-D2	4.00	DWELL (GAP GRINDER STEEL OD) DWELL CYL GRINDER OCC X OD		.01014		.046			
0060 E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093			
0080 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011			
0140	JA 01 15	.63		GR OD AREAS BETWEEN JOURNALS	.359	.034	.260	6		
0010 E	RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316			
0020 E	GTL-EP-A2	1.00	SET UP & DISMANTLE AIR DRILLS/U AIR GRINDER W/PAD/DISC		.00678		.007			
0030 E	RLG-RS-N3	1.00	NICK & BURR MED STRUT PART		.06711		.077			
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011			
0260	JA 01 15	.75		CHROME GRIND CENTER JOURNALS	1.595	.180	1.376	34		
0010 E	RGR-SU-P1	1.00	SET UP PLANETARY GRINDER	S/U SM/MED CYL GRINDER	.82175		.945			
0015 E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER CYL GRINDER	.02632		.030			
0020 E	KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02308		.053			
0030 E	KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155			
0040 E	RGR-GE-C2	18.00	GR CHROM OD (OCC FACT L X D) 1.5 X 4 X 3EA JOURNALS		.02189		.453			
0050 E	RGR-GE-D3	4.00	DWELL (GAP GRINDER CHROM OD) DWELL CYL GRINDER OCC X OD		.02029		.093			
0060 E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093			
0080 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011			
0270	JA 01 15	.25		CHROME GRIND LARGE JOURNALS	1.511	.057	.434	11		
0010 E	RGR-SU-P1	1.00	SET UP PLANETARY GRINDER	S/U SM/MED CYL GRINDER	.82175		.945			
0015 E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER CYL GRINDER	.02632		.030			
0020 E	KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02308		.053			
0030 E	KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155			
0040 E	RGR-GE-C2	16.00	GR CHROM OD (OCC FACT L X D) 2 X 4 X 2EA JOURNALS		.02189		.402			
0050 E	RGR-GE-D2	4.00	DWELL (GAP GRINDER STEEL OD) DWELL CYL GRINDER OCC X OD		.01014		.046			
0060 E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093			
0080 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011			

0280	JA 01	15	.13	CHROME GRIND SMALL JOURNALS	1.464	.029	.219	5
0010 E	RGR-SU-P1	1.00	SET UP PLANETARY GRINDER	S/U SM/MED CYL GRINDER	.82175		.945	
0015 E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER CYL GRINDER	.02632		.030	
0020 E	KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02308		.053	
0030 E	KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155	
0040 E	RGR-GE-C2	12.00	GR CHROM OD (OCC FACT L X D)	1.5 X 4 X 2EA JOURNALS	.02189		.302	
0050 E	RGR-GE-D3	4.00	DWELL (GAP GRINDER CHROM OD)	DWELL CYL GRINDER OCC X OD	.02029		.093	
0060 E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093	
0080 E	RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011	
0900			THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT					
0901			FOR THIS OPERATION WERE DETERMINED EITHER FROM					
0902			ACTUAL COUNT OR FROM REFERENCE TO T.O. SHOWN ABOVE					
9000	JA 01	15	.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010				PRIOR HISTORY ON 00-ALC 494 FORM				
0020				27JUN83 NEW OCC FACTOR STUDY & REMOVE ALL RJPPWF1				
0030				ELEMENTS <OLD STD> 1.17				
0031				27DEC84 2 YR REVIEW W/OCC CHANGE > OLD STD < 1.47				
0032				30JULY85 CHANGED SUB OP TO MATCH 958 NO TIME CHANG				
0039				J.CALDWELL TECH MANEAA				
0900				HANEL CLINTON BENTLEY MRP II 7-3255				

TO INTERROGATE LABOR STANDARDS, INPUT

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TECH S S W F P F A/R REV										A						
JOB	T K	#R A	FA	SUPPORT	OCC	DESCRIPTION				BASE	PFD	STD	A			
STEP	D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL				HOURS	TIME	HOURS	DLY	PCT C	
RD505	S	E	JA	EA 3	J 94154	.05	PERCENT ENGR 99.9	GRIND TRUNNION PIN 2EA 405				3.18		.15		
0001			JA	01	00	.00	PART NUMBER/NSN				.000	.000	.000		0	
0010							3G61014-101	1620000271196								
0060			JA	01	15	.67	GRIND TRUNNION PIN LARGE O.D				.925	.093	.713		22	
0010 E					RGR-SU-P1	.50	SET UP PLANETARY GRINDER	S/U SM/MED CYL GRINDER				.82175		.472		
0020 E					RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER CYL GRINDER				.02632		.030		
0030 E					KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND				.02308		.053		
0040 E					KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND				.06761		.155		
0050 E					RGR-GE-S2	16.00	GR STEEL OD (OCC FACT L X D)4 X 4					.01093		.201		
0060 E					RGR-GE-D2	4.00	DWELL (GAP GRINDER STEEL OD)DWELL CYL GRINDER OCC X OD					.01014		.046		
0070 E					RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5					.08102		.093		
0090 E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC					.01001		.011		
0070			JA	01	15	.33	GRIND TRUNNION PIN SMALL O.D				.789	.039	.300		9	
0010 E					RGR-SU-P1	.50	SET UP PLANETARY GRINDER	S/U SM/MED CYL GRINDER				.82175		.472		
0020 E					RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER CYL GRINDER				.02632		.030		
0030 E					KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND				.02308		.053		
0040 E					KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND				.06761		.155		
0050 E					RGR-GE-S2	5.00	GR STEEL OD (OCC FACT L X D)2 X 2.5					.01093		.062		
0060 E					RGR-GE-D2	2.50	DWELL (GAP GRINDER STEEL OD)DWELL CYL GRINDER OCC X OD					.01014		.029		
0070 E					RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5 PN 3G61014-101					.08102		.093		
0090 E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC					.01001		.011		
5			JA	01	15	.33	GRIND TRUNNION PIN HOLES				1.369	.068	.520		16	
0010 E					RGR-SU-J2	1.00	S-U JIG GRINDER LRG FIX-TBLE					.80167		.921		
0020 E					KMG-DW-ID	4.00	DRESS INTERNAL WHEEL	DRESS JIG GRINDER WHEEL OCCU				.02458		.113		
0021							ROUGH & FINISH GRIND 2EA HOLES									
0030 E					KMG-GW-LK	4.00	LOCATE WHEEL TO POSITION	OCC ROUGH & FINISH GRIND 2EA				.06761		.311		
0040 E					KMG-ID-AA	2.00	GRIND OUT .010-0.5 ID X 0.5 OCC FOR 2EA HOLES					.01367		.031		
0050 E					RGR-HM-C2	2.00	HANDLE & MEAS LENGTH 1 TO 5 OCC FOR 2EA HOLES					.08102		.186		
0070 E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC					.01001		.011		
0160			JA	01	15	.75	CHROME GRIND PIN LARGE O.D.				1.141	.128	.984		31	
0010 E					RGR-SU-P1	.50	SET UP PLANETARY GRINDER	S/U SM/MED CYL GRINDER				.82175		.472		
0020 E					RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER CYL GRINDER				.02632		.030		
0030 E					KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND				.02308		.053		
0040 E					KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND				.06761		.155		
0050 E					RGR-GE-C2	16.00	GR CHROM OD (OCC FACT L X D)4 X 4					.02189		.402		
0060 E					RGR-GE-D3	4.00	DWELL (GAP GRINDER CHROM OD)DWELL CYL GRINDER OCC X OD					.02029		.093		
0070 E					RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5					.08102		.093		
0090 E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC					.01001		.011		
0170			JA	01	15	.67	CHROME GRIND PIN SMALL O.D.				.869	.087	.670		21	
0010 E					RGR-SU-P1	.50	SET UP PLANETARY GRINDER	S/U SM/MED CYL GRINDER				.82175		.472		
0020 E					RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER CYL GRINDER				.02632		.030		
0030 E					KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND				.02308		.053		
0040 E					KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND				.06761		.155		
0050 E					RGR-GE-C2	5.00	GR CHROM OD (OCC FACT L X D)2 X 2.5					.02189		.125		
0060 E					RGR-GE-D3	2.50	DWELL (GAP GRINDER CHROM OD)DWELL CYL GRINDER OCC X OD					.02029		.058		
0070 E					RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5					.08102		.093		
0090 E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC					.01001		.011		
7900							THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT									
0901							FOR THIS OPERATION WERE DETERMINED EITHER FROM									
0902							ACTUAL COUNT OR FROM REFERENCE TO T.O. SHOWN ABOVE									
9000			JA	01	15	.01	LABOR STANDARD HISTORY				.000	.000	.000		0	
0010							PRIOR HISTORY ON DD-ALC 494 FORM									
0020							27JUN83 NEW OCC FACTOR STUDY & REMOVE ALL RJPWF1									

0030  
0031  
0032  
0899  
0900

ELEMENTS <OLD STD> .23  
27DEC84 2 YR REVIEW W/OCC CHANGE > OLD STD < 1.07  
30JULY85 CHANGED SUE OP TO MATCH 958 NO TIME CHANG  
J.CALDWELL TECH MANEAA  
MANEL CLINTON BENTLEY MRP II 7-3255

TO INTERROGATE LABOR STANDARDS, INPUT

RCC FRD NROP NR

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## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

01/29/88

A-E046B-MM1-DY-M45 PAGE 0001

74521A STRUT ASSY C-141 NLG

RCC MNPRB

4S2-59-3

TECH S S W F PF A/R REV

SUB	T K	#R A FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A
STEP	D L	K C DC	ELEMENT	FACT	STORED	HOURS	TIME	HOURS	DLY PCT C
RB508	S E	JA EA 3	J 84154	.05	PERCENT ENGR 99.9	GRIND TRUNNION PIN 2EA 405	3.18	.15	
0001		JA 01	00	.00	PART NUMBER/NSN	.000	.000	.000	0
0020					3G61039-101 1620007575889				
0060		JA 01	15	.67	GRIND TRUNNION PIN LARGE O.D	.925	.093	.713	22
0010 E			RGR-SU-P1	.50	SET UP PLANETARY GRINDER S/U SM/MED CYL GRINDER	.82175		.472	
0020 E			RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER ADJUST TAPER CYL GRINDER	.02632		.030	
0030 E			KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL OCC FOR ROUGH & FINISH GRIND	.02308		.053	
0040 E			KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION OCC FOR ROUGH & FINISH GRIND	.06761		.155	
0050 E			RGR-GE-S2	16.00	GR STEEL OD (OCC FACT L X D) 4 X 4	.01093		.201	
0060 E			RGR-GE-D2	4.00	DWELL (GAP GRINDER STEEL OD) DWELL CYL GRINDER OCC X OD	.01014		.046	
0070 E			RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5	.08102		.093	
0090 E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0080		JA 01	15	.33	GRIND TRUNNION PIN SMALL O.D	.789	.039	.300	9
0010 E			RGR-SU-P1	.50	SET UP PLANETARY GRINDER S/U SM/MED CYL GRINDER	.82175		.472	
0020 E			RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER ADJUST TAPER CYL GRINDER	.02632		.030	
0030 E			KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL OCC FOR ROUGH & FINISH GRIND	.02308		.053	
0040 E			KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION OCC FOR ROUGH & FINISH GRIND	.06761		.155	
0050 E			RGR-GE-S2	5.00	GR STEEL OD (OCC FACT L X D) 2 X 2.5	.01093		.062	
0060 E			RGR-GE-D2	2.50	DWELL (GAP GRINDER STEEL OD) DWELL CYL GRINDER OCC X OD	.01014		.029	
0070 E			RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5 PN 3G61039-101	.08102		.093	
0090 E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
35		JA 01	15	.33	GRIND TRUNNION PIN HOLES	1.369	.068	.520	16
0010 E			RGR-SU-J2	1.00	S-U JIG GRINDER LRG FIX-TBLE	.80167		.921	
0020 E			KMG-DW-ID	4.00	DRESS INTERNAL WHEEL DRESS JIG GRINDER WHEEL OCCU	.02458		.113	
0021					ROUGH & FINISH GRIND 2EA HOLES				
0030 E			KMG-GW-LK	4.00	LOCATE WHEEL TO POSITION OCC ROUGH & FINISH GRIND 2EA	.06761		.311	
0040 E			KMG-ID-AA	2.00	GRIND OUT .010-0.5 ID X 0.5 OCC FOR 2EA HOLES	.01367		.031	
0050 E			RGR-HM-C2	2.00	HANDLE & MEAS LENGTH 1 TO 5 OCC FOR 2EA HOLES	.08102		.186	
0070 E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0160		JA 01	15	.75	CHROME GRIND PIN LARGE O.D.	1.141	.128	.984	31
0010 E			RGR-SU-P1	.50	SET UP PLANETARY GRINDER S/U SM/MED CYL GRINDER	.82175		.472	
0020 E			RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER ADJUST TAPER CYL GRINDER	.02632		.030	
0030 E			KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL OCC FOR ROUGH & FINISH GRIND	.02308		.053	
0040 E			KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION OCC FOR ROUGH & FINISH GRIND	.06761		.155	
0050 E			RGR-GE-C2	16.00	GR CHROM OD (OCC FACT L X D) 4 X 4	.02189		.402	
0060 E			RGR-GE-D3	4.00	DWELL (GAP GRINDER CHROM OD) DWELL CYL GRINDER OCC X OD	.02029		.093	
0070 E			RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5	.08102		.093	
0090 E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0170		JA 01	15	.67	CHROME GRIND PIN SMALL O.D.	.869	.087	.670	21
0010 E			RGR-SU-P1	.50	SET UP PLANETARY GRINDER S/U SM/MED CYL GRINDER	.82175		.472	
0020 E			RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER ADJUST TAPER CYL GRINDER	.02632		.030	
0030 E			KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL OCC FOR ROUGH & FINISH GRIND	.02308		.053	
0040 E			KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION OCC FOR ROUGH & FINISH GRIND	.06761		.155	
0050 E			RGR-GE-C2	5.00	GR CHROM OD (OCC FACT L X D) 2 X 2.5	.02189		.125	
0060 E			RGR-GE-D3	2.50	DWELL (GAP GRINDER CHROM OD) DWELL CYL GRINDER OCC X OD	.02029		.058	
0070 E			RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5	.08102		.093	
0090 E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0900					THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT				
0901					FOR THIS OPERATION WERE DETERMINED EITHER FROM				
0902					ACTUAL COUNT OR FROM REFERENCE TO T.O. SHOWN ABOVE				
9000		JA 01	15	.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010					PRIOR HISTORY ON 00-ALC 494 FORM				
0020					27JUN83 NEW OCC FACTOR STUDY & REMOVE ALL RJPPWF1				

0030  
0031  
0032  
0899  
0900

ELEMENTS <OLD STD> .23  
27DEC84 2 YR REVIEW W/OCC CHANGE > OLD STD < 1.07  
30JULY85 CHANGED SUB OP TO MATCH 958 NO TIME CHANG  
J.CALDWELL TECH MANEAA  
MANEL CLINTON BENTLEY MRP II 7-3255

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS  
RCC MNPRB

01/29/88  
4S2-59-3

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74521A STRUT ASSY C-141 NLG

TECH S S		W F PF A/R REV		OCC		DESCRIPTION		BASE		STD		A	
SUB	T K	#R A	FA SUPPORT	FACT	STORED	SUPPLEMENTAL		HOURS	PFD TIME	HOURS	DLY	PCT	C
STEP	D L	K C	DC ELEMENT										
RB511	S	E	JA	EA 3	J 84154	.14 PERCENT ENGR 99.9	GRIND STEERING COLLAR 405	9.48		1.32			
0001			JA	01	00	.00	PART NUMBER/NSN	.000	.000	.000		0	
0010						3G61092-111	1620009294672						
0070			JA	01	15	.25	1ST GRIND COLLAR I.D.	1.908	.072	.549		6	
0010	E		RGR	SU-G1	1.00	SET UP A GAP GRINDER	S/U INTERNAL GRINDER	1.05938		1.218			
0020	E		RGR	HM-T2	1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER INTERNAL GRIND	.02632		.030			
0030	E		RGR	HM-S3	1.00	GAP GRINDER TURN OFF & ON	TURN OFF/ON INTERNAL GRINDER	.00685		.007			
0040	E		KMG	DW-ID	2.00	DRESS INTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02458		.056			
0050	E		KMG	GW-LK	2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155			
0060	E		KMG	ID-ND	1.09	GRIND OUT .010 6.0 I X 2.0	OCC FOR 6.5 I.D.	.49631		.622			
0070	E		RGR	HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093			
0090	E		RJP	PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011			
0080			JA	01	15	1.80	1ST GRIND FACES OCC 2EA	2.177	.588	4.507		48	
0010						FACES							
0020	E		RGR	SU-G1	1.00	SET UP A GAP GRINDER	S/U SURFACE GRINDER	1.05938		1.218			
0030	E		RGR	HM-S3	1.00	GAP GRINDER TURN OFF & ON	TURN OFF/ON SURFACE GRINDER	.00685		.007			
0040	E		KMG	DW-OD	2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02308		.053			
0050	E		KMG	GW-LK	2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155			
0060	E		KMG	OD-CH	8.00	GRIND .040 1 OD X 2	1 X 8 4 EA OCC	.09467		.870			
0070	E		RGR	GE-D2	8.00	DWELL (GAP GRINDER STEEL OD)	DWELL SURFACE GRINDER 8IN OD	.01014		.093			
0080	E		RGR	HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093			
0100	E		RJP	PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011			
0160			JA	01	15	.25	CHROME GRIND I.D.	2.465	.092	.709		7	
0010	E		RGR	SU-G1	1.00	SET UP A GAP GRINDER	S/U INTERNAL GRINDER	1.05938		1.218			
0020	E		RGR	HM-T2	1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER INTERNAL GRIND	.02632		.030			
0030	E		RGR	HM-S3	1.00	GAP GRINDER TURN OFF & ON	TURN OFF/ON INTERNAL GRINDER	.00685		.007			
0040	E		KMG	DW-ID	2.00	DRESS INTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02458		.056			
0050	E		KMG	GW-LK	2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155			
0060	E		KMG	ID-NJ	1.09	GRIND OUT .040 6.0 ID X 2.0	OCC FOR 6.5 I.D.	1.00729		1.262			
0070	E		RGR	HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093			
0090	E		RJP	PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011			
0170			JA	01	15	.80	CHROME GRIND COLLAR FACE 1EA	1.798	.216	1.655		17	
0005						2EA FACES							
0010	E		RGR	SU-G1	1.00	SET UP A GAP GRINDER	S/U SURFACE GRINDER	1.05938		1.218			
0020	E		RGR	HM-S3	1.00	GAP GRINDER TURN OFF & ON	TURN OFF/ON SURFACE GRINDER	.00685		.007			
0030	E		KMG	DW-OD	2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02308		.053			
0040	E		KMG	GW-LK	2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155			
0050	E		KMG	OD-CH	4.00	GRIND .040 1 OD X 2	1 X 8 4EA OCC.	.09467		.435			
0060	E		RGR	GE-D2	8.00	DWELL (GAP GRINDER STEEL OD)	DWELL SURFACE GRINDER 8IN OD	.01014		.093			
0070	E		RGR	HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093			
0090	E		RJP	PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011			
0240			JA	01	15	1.00	CHROME GRIND OPPOSITE FACE	1.798	.270	2.068		22	
0010	E		RGR	SU-G1	1.00	SET UP A GAP GRINDER	S/U SURFACE GRINDER	1.05938		1.218			
0020	E		RGR	HM-S3	1.00	GAP GRINDER TURN OFF & ON	TURN OFF/ON SURFACE GRINDER	.00685		.007			
0030	E		KMG	DW-OD	2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02308		.053			
0040	E		KMG	GW-LK	2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155			
0050	E		KMG	OD-CH	4.00	GRIND .040 1 OD X 2	1 X 8 4EA OCC.	.09467		.435			
0060	E		RGR	GE-D2	8.00	DWELL (GAP GRINDER STEEL OD)	DWELL SURFACE GRINDER 8IN OD	.01014		.093			
0070	E		RGR	HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093			
0090	E		RJP	PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011			
0900						THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT							
0901						FOR THIS OPERATION WERE DETERMINED EITHER FROM							
0902						ACTUAL COUNT OR FROM REFERENCE TO T.O. SHOWN ABOVE							

.9000	JA 01 15	.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010			PRIOR HISTORY ON 00-ALC 494 FORM				
0020			27JUN83 NEW OCC FACTOR STUDY & REMOVE ALL RJPPWF1				
0030			ELEMENTS <OLD STD> 1.96				
0031			27DEC84 2 YR REVIEW W/ OCC CHANGE > OLD STD < .97				
0032			25FEB85 CHANGED ELINENT RLGGES2 TO KMGODCH 3 EA				
0033			PLACES TO COVER WHAT IS DONE MORE DIF. PART				
0034			30JULY85 CHANGED SUB OP TO MATCH 958 NU TIME CHANG				
0899			J.CALDWELL TECH MANEAA				
0900			MANEL CLINTON BENTLEY MRP II 7-3255				

TO INTERROGATE LABOR STANDARDS, INPUT

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**SUPPLEMENTAL**

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TECH S S		W F PF A/R REV		OCC		DESCRIPTION		BASE		PFD		STD		DLY PCT	
JOB	T K	R A	FA	SUPPORT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	TIME	HOURS	TIME		
STEP	D L	K C	DC	ELEMENT											
00010	E	N	HB	EA 5	J 87349	1.00 PERCENT ENGR 10.1	ASSY STRUT C141 N.L.G.	6.66				6.66			
0001			HB	01	00	1.00	PART NUMBER/NSN	.000	.000	.000				0	
	0010					3660005-141	1620001877445								
0490			HB	01	21	1.00	PRE TEST FILLER TUBE	.250	.053	.303	2.4	5			
	0010	E			ZPT-CL-M1	1.00 PRESSURE TEST MED SIZE CYL		.24000		.290					
	0020	E			RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.012					
0501			HB	01	21	1.00	OK TO CLOSE/OR ASSEMBLE	.212	.045	.257		4			
	0010	N				1.00	OK TO CLOSE	.20200		.244					
	0020	E			RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.012					
0503			HB	01	21	1.00	REASSEMBLE IN REV ORDER	1.010	.212	1.222		18			
	0010	N				1.00	SIGN OFF PARTS USED	1.00000		1.210					
	0020	E			RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.012					
0505			HB	01	21	1.00	REASSEMBLE	3.010	.632	3.642		55			
	0010	N				1.00	REASSEMBLE	3.00000		3.630					
	0020	E			RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.012					
0507			HB	01	21	1.00	TORQUE ALL NUTS & BOLTS	.760	.160	.920		14			
	0010	N				1.00	APPLY TORQUE TO ALL	.75000		.907					
	0020	E			RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.012					
0510			HB	01	21	1.00	PRESSURE TEST	.266	.056	.323	2.4	5			
	0010	E			RLG-SF-L2	1.00 LEAK CHECK MEDIUM CAP STRUT		.25695		.310					
	0020	E			RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.012					
0900			HB	01	21	.01	LABOR STANDARD HISTORY	.000	.000	.000		0			
	0010					PRIOR HISTORY ON DD-MLC 494 FORM									
	0020					23JUN83 UPDATE OPERATION <OLD STD>	5.60								
	0021					27DEC84 2 YR REVIEW W/ NO CHANGES									
	0900					JENSEN HANEL	73255								

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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# LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/01/88

A-E046B-NH1-DY-M45 PAGE 00

74521A STRUT ASSY C141 NLG

RCC MHPGP

4S2-59-3

SUB	TECH S S		W F PF A/R REV		OCC	DESCRIPTION		BASE HOURS	PFD TIME	STD HOURS	DLY PCT
	STEP	D L	K C	DC		STORED	SUPPLEMENTAL				
PP502	S	E	3S	EA	5	J 87343	1.00 PERCENT ENGR 99.9				
0001			3S	01	00			.54		.54	
								.000	.000	.000	
0010						3661089-111	1620004983226				
0447			3S	01	25		PRE PAINT	.436	.109	.546	4.0 100
0010	E					ZPA-PP-C2	1.00 PREPAINT I.D. MED STRUT PART	.42668		.533	
0020	E					RJP-PW-R1	1.00 REM RPL PAPRUSK SIGN OFF DOC	.01001		.012	
9000			3S	01	00		LABOR STANDARD HISTORY	.000	.000	.000	
0010						9DEC87 INITIAL INPUT BUILT TO MATCH 958					
0900						JENSEN	HANEL				
							73255				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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TECH S S		W F PF A/R REV		OCC		DESCRIPTION		BASE HOURS	PFD TIME	STD HOURS	DLY PC
SUB	T K	R A	FA	SUPPORT	FACT	STORED	SUPPLEMENTAL				
STEP	D L	K C	DC	ELEMENT	FACT						
PP503	3	E	3S	EA 5	J 87345	1.00 PERCENT ENGR 99.9	PRE PAINT AXLE -	.54		.54	
0001			3S	01 00		.00	PART NUMBER/MSN	.000	.000	.000	
0010						3661032-107	1620009272599				
0357			3S	01 25		1.00	PAINT NON CHROME SURFACES	.436	.109	.546	4.0 10
0010 E				ZPA-PP-C2	1.00	PREPAINT I.D. MED STRUT PART		.42668		.533	
0020 E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
9000			3S	01 00		.00	LABOR STANDARD HISTORY	.000	.000	.000	
0010						11DEC87 INITIAL INPUT	BUILT TO MATCH 958				
0900						JENSEN	HANEL 73255				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NWPG NR  
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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 02/01/88 A-E046B-MM1-DY-M45 PAGE  
74521A STRUT ASSY C141 MLG RCC MHPGP 452-59-3

SUB	TECH S S	W F F A/R REV	STEP D L	K R A FA SUPPORT	K C DC ELEMENT	OCC <-----	DESCRIPTION	BASE HOURS	PFD TIME	STD HOURS	DLY P
						FACT	STORED	SUPPLEMENTAL			
PP504	S	E	3S	EA	5	J 87344	1.00 PERCENT ENGR 99.9	PRE PAINT TRUNNION	1.09		1.09
0001			3S	01	00		.00	PART NUMBER/NSN	.000	.000	.000
0010							8340783-10	1620001947597			
0020							8340783-30	MSL			
0400			3S	01	25		1.00	PRE PAINT CENTER TRUNNION ID	.436	.109	.546 4.0 5
0010 E						ZPA-PP-C2	1.00 PREPAINT I.D. MED STRUT PART	CENTER TRUNNION I.D.	.42668		.533
0020 E						RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.012
0410			3S	01	25		1.00	PAINT TRUNNION END I.D.	.436	.109	.546 4.0 5
0010 E						ZPA-PP-C2	1.00 PREPAINT I.D. MED STRUT PART	TRUNNION END I.D.	.42668		.533
0020 E						RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.012
9000			3S	01	00		.00	LABOR STANDARD HISTORY	.000	.000	.000
0010							10DEC87 INITIAL INPUT	BUILT TO MATCH 958			
0900							JENSEN	MAMEL			
								73255			

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

<---X---X--->

1234567890123456 ELSE PUT IN END

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 02/01/88 A-E0468-MH1-DY-M45 PAGE  
74521A STRUT ASSY C141 MLG RCC NMPCP 4S2-59-3  
TECH S S W F PF A/R REV  
SUB T K #R A FA SUPPORT OCC <----- DESCRIPTION -----> BASE PFD STD  
STEP D L K C DC ELEMENT FACT STORED SUPPLEMENTAL HOURS TIME HOURS DLY P

PP505	S	E	3S	EA	5	J	87344	1.00	PERCENT ENGR 99.9	PRE PAINT TRUNNION PINS	.37		.37	
0001			3S	00	00			.00		PART NUMBER/NSN	.000	.000	.000	
0010									3661014-101	1620000271196				
0227			3S	01	25			1.00		PRE PAINT PINS	.296	.074	.371	4.0 1
0010 E								1.00	PREPAINT SMALL STRUT PART	TRUNNION PIN	.29676		.370	
9000			3S	00	00			.00		LABOR STANDARD HISTORY	.000	.000	.000	
0010									410DEC87 INITIAL INPUT BUILT TO MATCH 958					
0900									JENSEN	MANEL				73255

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR  
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?







INC/511-478

244

ST-STEEL  
 AL-ALUMINUM  
 MAG-MAGNESIUM  
 TIT-TITANIUM  
 ZN-ZINC  
 SYN-ARTIFICIAL  
 UN-UNKNOWN

**f-15 N.L.b.**

**Bill of Materials**

174024

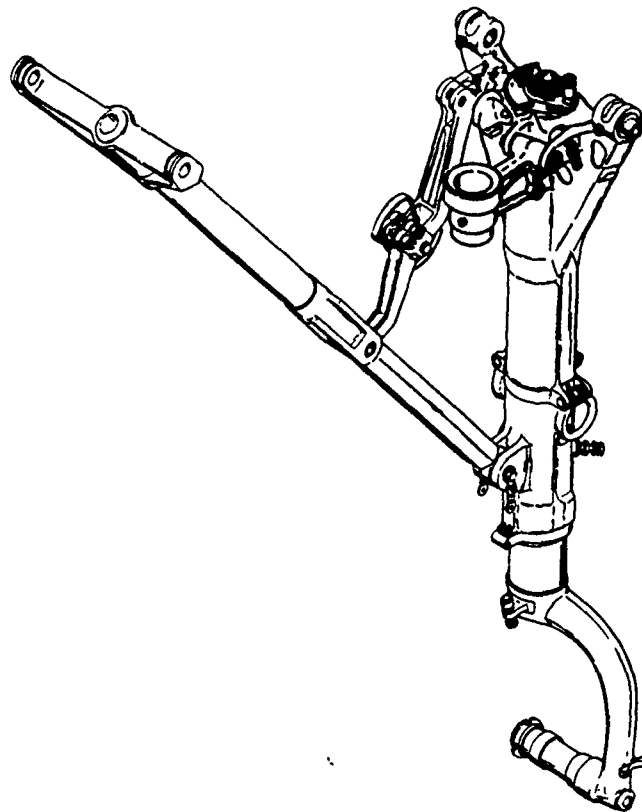
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# Bill of Materials

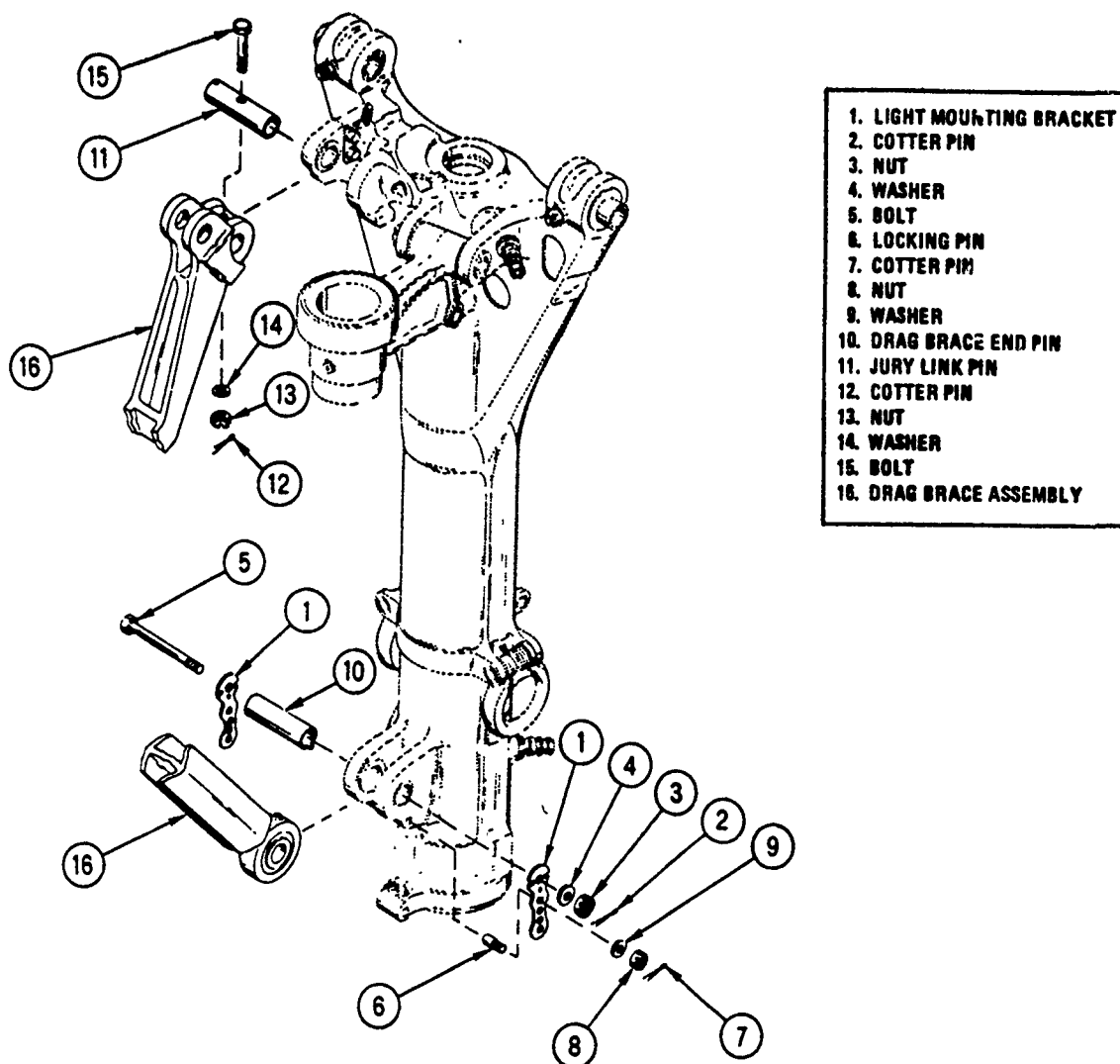
209

F-15 NLG



452-73-3-(11)

Nose Landing Gear Assembly



452-73-3-(11)

Figure 3-1. Removing Drag Brace from Shock Strut, Exploded View

**3-5. DISASSEMBLING DRAG BRACE.** See figure 3-2.

a. Remove cotter pin (2), nut (3), washer (4), and bolt (5) securing apex pin (1). Drive out apex pin, then separate lower jury link (40) and lower drag brace (9) from upper drag brace (51).

b. Do not remove flanged bushings (6), spherical bearing (7), or fittings (8) from lower drag brace (9) unless inspection indicates that replacement is necessary.

c. If linear actuating cylinder attaching parts were left on upper jury link (37), remove cotter pin (11), nut (12), washer (13), and bolt (10) from upper jury link.

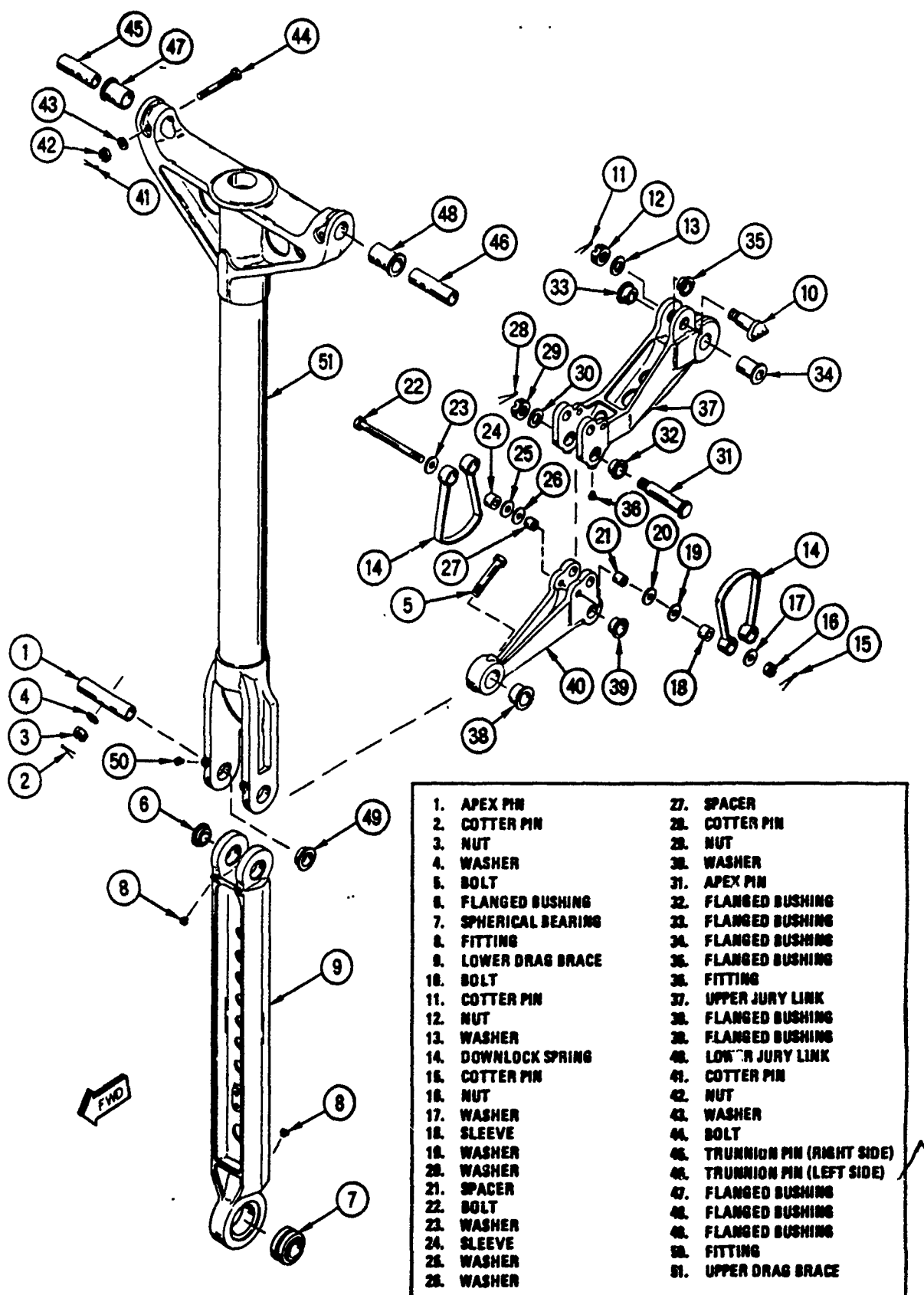
d. Remove cotter pins (15), nuts (16), washers (17), and adjacent downlock spring (14). Remove spring sleeves (18), washers (19), washer (20), and spacer (21) from left side of jury links. From opposite side

of jury links, remove bolts (22), washers (23), spring sleeve (24), washers (25), washer (26), and spacer (27).

e. Remove cotter pin (28), nut (29), washer (30), and apex pin (31); separate upper jury link (37) assembly from lower jury link (40). Do not remove flanged bushings (32, 33, 34, and 35) or fittings (36) from upper jury link unless inspection indicates that replacement is necessary.

f. Do not remove flanged bushings (38 and 39) from lower jury link (40) unless inspection indicates that replacement is necessary.

g. Remove cotter pins (41), nuts (42), washers (43), bolts (44), and trunnion pins (45 and 46). Do not remove flanged bushings (47, 48, and 49) or fittings (50) from upper drag brace (51) unless inspection indicates that replacement is necessary.



4S2-73-3-(2)

Figure 3-2. Drag Brace, Exploded View

5. REMOVING PISTON AND ORIFICE SUPPORT TUBE FROM CYLINDER. See figure 3-3.

**CAUTION**

To prevent damage to unpainted or bare metal parts, handle with extreme care as they may be easily damaged.

- a. Discharge high then low pressure chambers.

**NOTE**

Nose landing gear is to be drained of all oil.

- b. Remove oil valve (47, figure 3-7) drain oil, and install oil valve.

- c. Rotate piston assembly (15, figure 3-3) as necessary to gain access to lock tab (1) and bolts (4). Remove nuts (2), washers (3), bolts (4), washers (5), and lock tab. Remove steering crank nut (7) and steering crank (6) from end of orifice support tube (14).

- d. Remove nut (22) and washer (23) from steering crank (6).

- e. Place strut in horizontal position and remove cotter pins (9), nuts (10), washers (11), and bolts (12). Remove instruction plate (13) if installed. Remove lock tab (8) securing gland nut (17). Unscrew gland nut to disengage from cylinder threads.

- f. Provide a drain pan under cylinder to catch oil. Pull piston assembly (15) and orifice support tube (14) out of cylinder assembly (16).

3-7. REMOVING ORIFICE SUPPORT TUBE FROM PISTON. See figure 3-4.

**CAUTION**

To prevent damage to unpainted or bare metal parts, handle with extreme care as they may be easily damaged.

**NOTE**

Plate (1, figure 3-4) and bearing (2) may remain in cylinder when piston and orifice support tube are removed.

- a. If necessary, remove plate (1) and bearing (2) from cylinder bore. Remove retainer (3) from shoulder of orifice support tube (7). Keep parts together.

- b. Push orifice support tube (7) into piston (8) sufficiently to disengage tube from wear plates (4).

- c. Remove wear plates (4), shims (5), and shoes (6) from inside barrel of piston (8).

- d. Withdraw orifice support tube (7) from piston (8).

1. LOCK TAB
2. NUT
3. WASHER
4. BOLT
5. WASHER
6. STEERING CRANK
7. STEERING CRANK NUT
8. LOCK TAB
9. COTTER PIN
10. NUT
11. WASHER
12. BOLT
13. INSTRUCTION PLATE
14. ORIFICE SUPPORT TUBE
15. PISTON ASSEMBLY
16. CYLINDER ASSEMBLY
17. GLAND NUT
18. LOWER BEARING
19. LOWER CAM
20. UPPER CAM
21. SCRAPER
22. NUT
23. WASHER

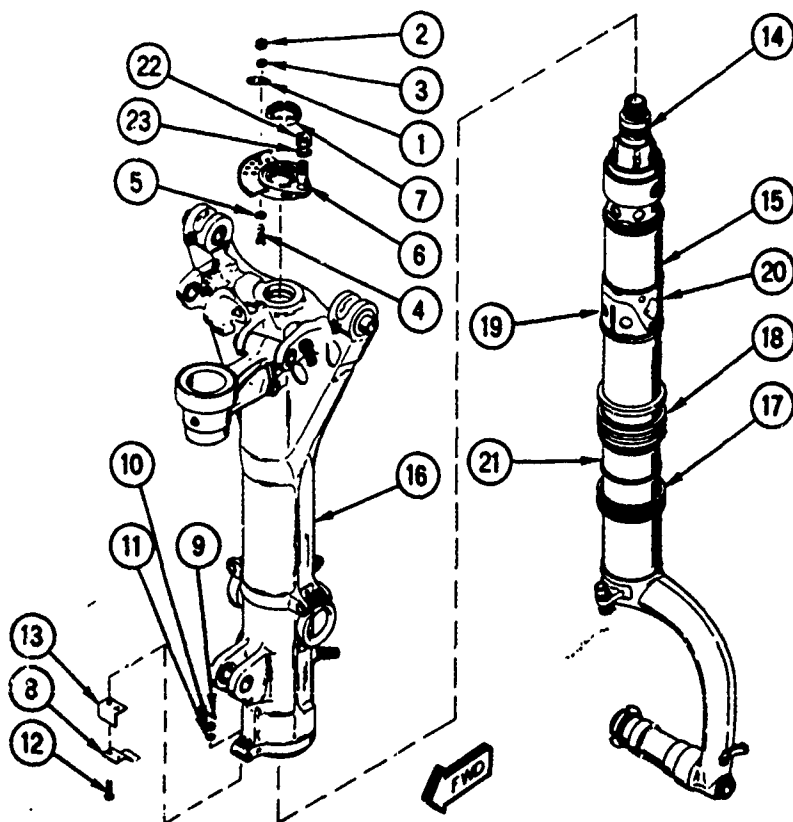
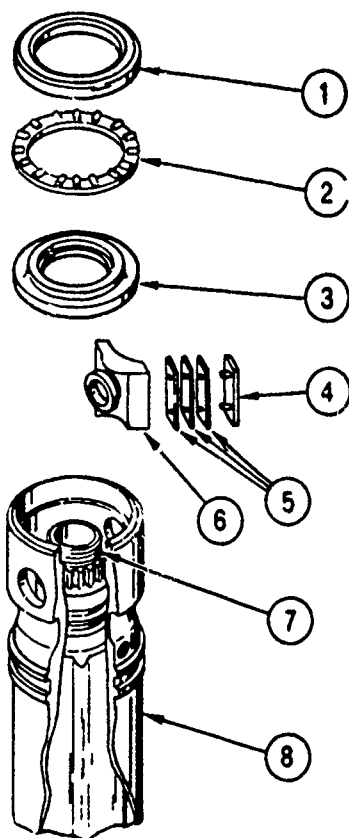


Figure 3-3. Removing Piston and Orifice Support Tube from Cylinder, Exploded View





- |    |                      |
|----|----------------------|
| 1. | PLATE                |
| 2. | BEARING              |
| 3. | RETAINER             |
| 4. | WEAR PLATE           |
| 5. | SHIMS                |
| 6. | SHOE                 |
| 7. | ORIFICE SUPPORT TUBE |
| 8. | PISTON               |

Figure 3-4. Removing Orifice Support Tube from Piston, Exploded View

### 3-8. DISASSEMBLING ORIFICE SUPPORT TUBE ASSEMBLY. See figure 3-5.

#### CAUTION

To prevent damage to unpainted or bare metal parts, handle with extreme care as they may be easily damaged.

- a. Remove retainer rings (1) and packings (2) below splines from orifice support tube (32).

#### NOTE

Assembly consisting of index Nos. 3 through 28, figure 3-5, are not to be disassembled except for replacement of obviously damaged and/or unserviceable parts. Disassembly is to be limited to that level required to replace those components identified as unserviceable.

- b. Cut lockwire, then remove screw (4) and lock plate (3).

- c. Remove body assembly (5 through 20) from orifice support tube extension (28). Remove retainers (21 and 22), ring (23), and spacer (24).

- d. To disassemble body assembly (5 through 20) remove three screws (5) securing spring stop (6). Remove spring stop and spring (7) from bore of body (20). Remove two screws (9), then separate band (8) securing pins (10). Remove pins, then slide sleeve (11) out of body bore. Slide retainer (14) away from retainer ring (12); remove cotter pin (13), retainer ring (12), and retainer (14). Remove check valve (15) from end of body. Remove stop (16) from bore of body. Do not remove inserts (17, 18, and 19) from body unless inspection indicates that replacement is necessary.

- e. Cut lockwire, then remove screws (26) and lock plate (25). Remove extension (28) from end of orifice support tube (32). Do not remove inserts (27) from extension unless inspection indicates that replacement is necessary.

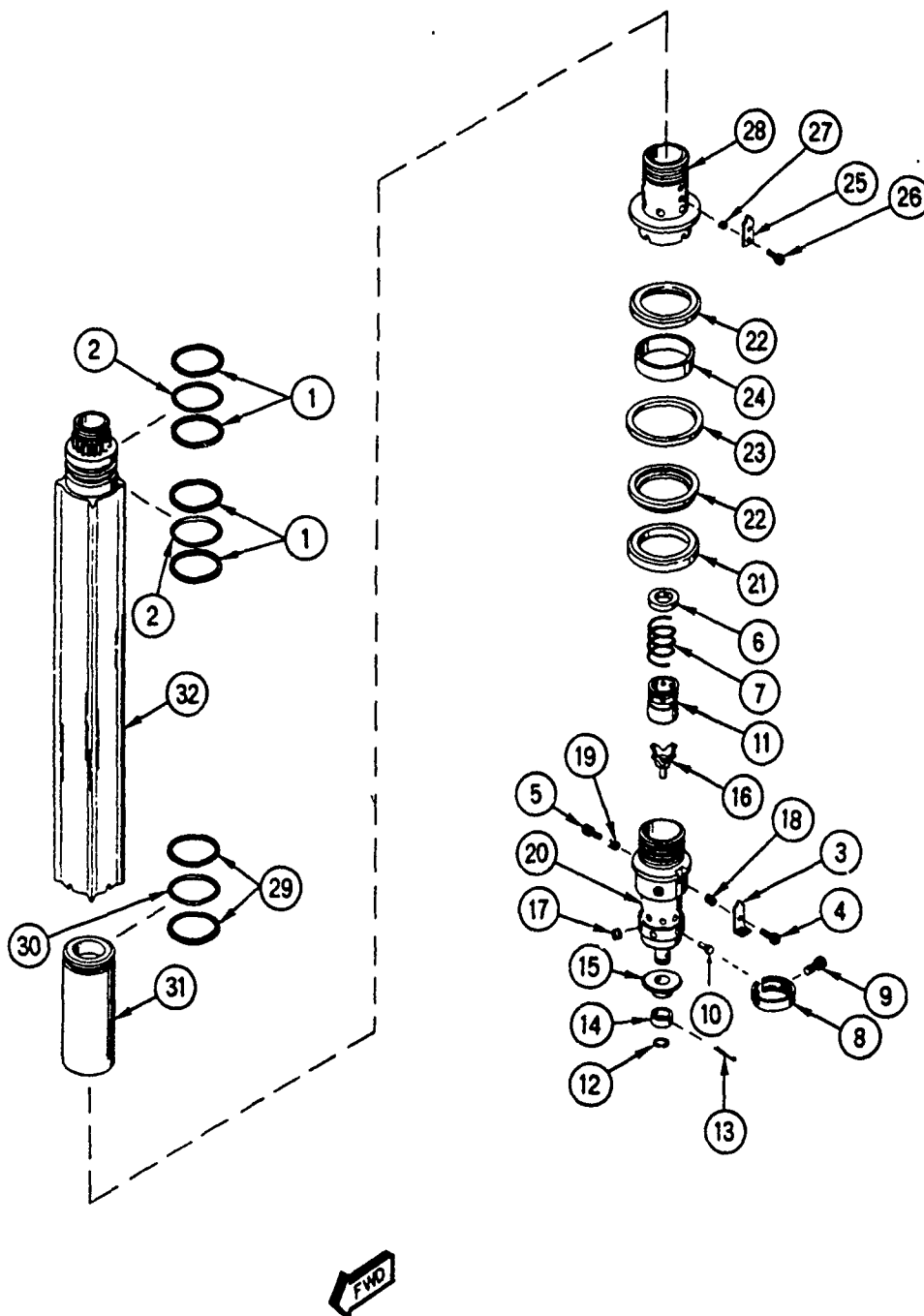
- f. Bump orifice support tube (32) on bench or use air pressure administered through hole in top of orifice support tube to remove piston (31). Remove retainer rings (29) and packing (30) from piston.

### 3-9. DISASSEMBLING PISTON. See figure 3-6.

#### CAUTION

To prevent damage to unpainted or bare metal parts handle with extreme care as they may be easily damaged.

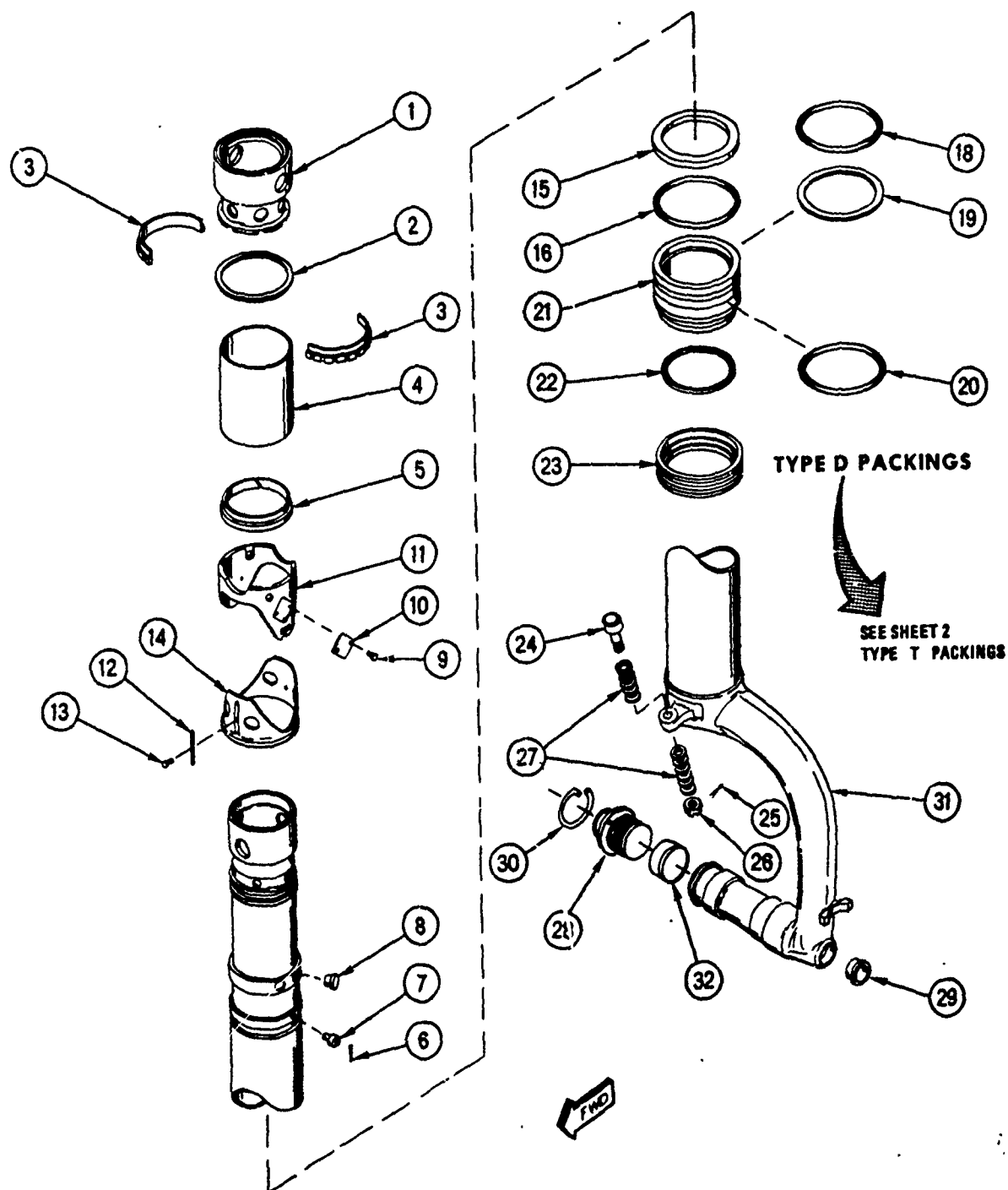
- a. Slide head (1) off barrel of piston (31); remove snubber valve (2) and split retainers (3). Remove spacer (4) and support (5) from piston.



1. RETAINER RING	9. SCREW	17. INSERT	25. LOCK PLATE
2. PACKING	10. PIN	18. INSERT	26. SCREW
3. LOCK PLATE	11. SLEEVE	19. INSERT	27. INSERT
4. SCREW	12. RETAINER RING	20. BODY	28. EXTENSION
5. SCREW	13. COTTER PIN	21. RETAINER	29. RETAINER RING
6. SPRING STOP	14. RETAINER	22. RETAINER	30. PACKING
7. SPRING	15. CHECK VALVE	23. RING	31. PISTON
8. BAND	16. STOP	24. SPACER	32. ORIFICE SUPPORT TUBE

4S2-73-3-(6)

Figure 3-5. Orifice Support Tube Assembly, Exploded View



- |                   |                    |                     |
|-------------------|--------------------|---------------------|
| 1. HEAD           | 11. UPPER CAM      | 22. SCRAPER         |
| 2. SNUBBER VALVE  | 12. KEY            | 23. GLAND NUT       |
| 3. SPLIT RETAINER | 13. RIVET          | 24. CAM FOLLOWER    |
| 4. SPACER         | 14. LOWER CAM      | 25. COTTER PIN      |
| 5. SUPPORT        | 15. RETAINER       | 26. NUT             |
| 6. COTTER PIN     | 16. PACKING        | 27. WASHER          |
| 7. APEX PIN       | 17. RETAINER RINGS | 28. AXLE NUT        |
| 8. PIN            | 18. PACKING        | 29. FLANGED BUSHING |
| 9. RIVET          | 19. RETAINER RINGS | 30. AXLE NUT SPRING |
| 10. INSERT        | 20. SPARE PACKING  | 31. PISTON          |
|                   | 21. LOWER BEARING  | 32. NYLON PLUG      |

492-73-3-(8-11)

Figure 3-6. Piston, Exploded View (Sheet 1 of 2)

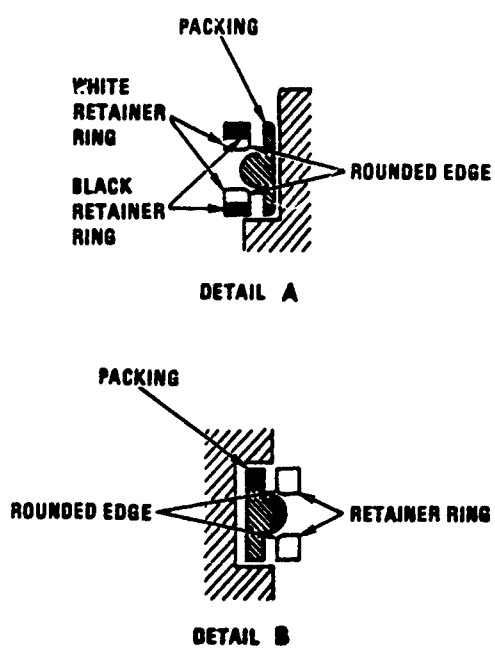
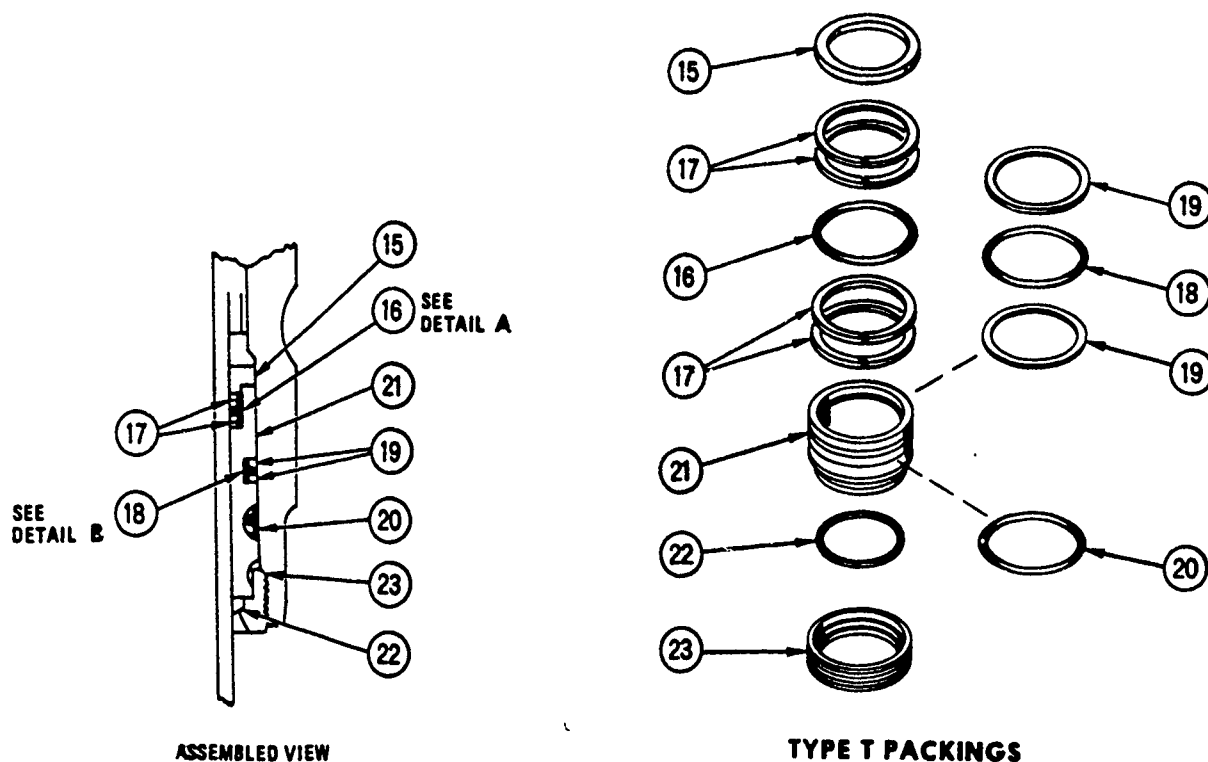
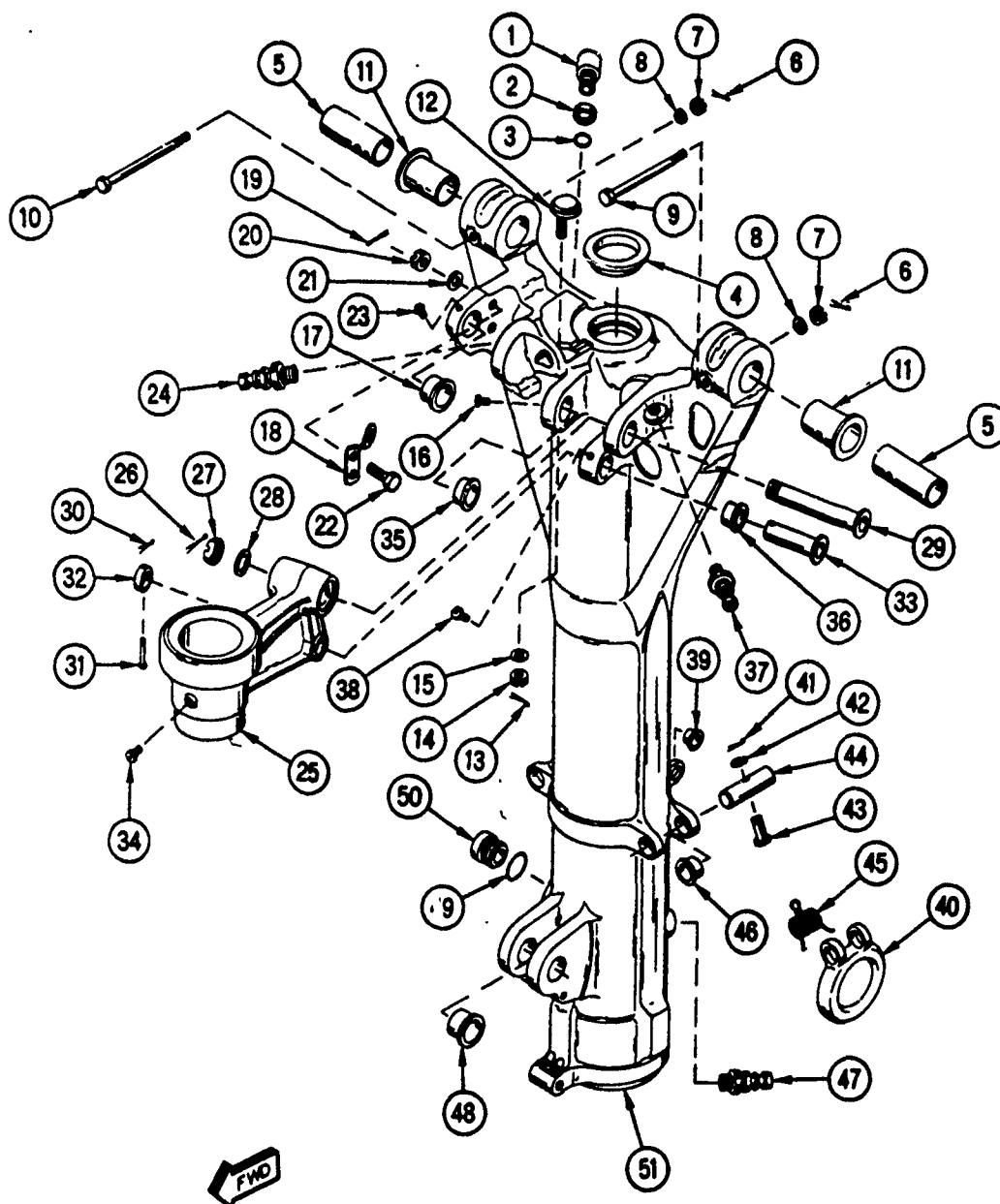


Figure 3-6. Piston, Exploded View (Sheet 2)

4S2-73-3-16-2/8



1. PRESSURE GAGE	14. NUT	27. NUT	40. TIE DOWN RING
2. NUT	15. WASHER	28. WASHER	41. COTTER PIN
3. PACKING	16. FITTING	29. UPPER BOLT	42. WASHER
4. FLANGED BUSHING	17. FLANGED BUSHING	30. COTTER PIN	43. STRAIGHT PIN
5. TRUNNION PIN	18. SWITCH MOUNT BRACKET	31. STRAIGHT PIN	44. TIE DOWN RING PIN
6. COTTER PIN	19. COTTER PIN	32. COLLAR	45. SPRING
7. NUT	20. NUT	33. LOWER PIN	46. FLANGED BUSHING
8. WASHER	21. WASHER	34. FITTING	47. OIL VALVE
9. BOLT	22. BOLT	35. FLANGED BUSHING	48. FLANGED BUSHING
10. BOLT	23. FITTING	36. FLANGED BUSHING	49. PACKING
11. FLANGED BUSHING	24. AIR VALVE	37. AIR VALVE	50. PLUG
12. INSERT	25. SUPPORT ARM	38. FITTING	51. CYLINDER
13. COTTER PIN	26. COTTER PIN	39. FLANGED BUSHING	

## NOTE

ⓘ PLUG AN614-100L AND PACKING MS28778-10 ARE FOR SHIPPING PURPOSES ONLY.

Figure 3-7. Cylinder, Exploded View

452-73-3-171A

# FAMILY 4

CONTROL NUMBER LIST

LABO TECH	PLAN TECH	CONTROL NUMBER	JOP DESC	AIRCRAFT	DESCRIPTION	STOCK NUMBER	PART NUMBER	TECH ORDER
COOP	COOP	16283A		C-141 MLG	DRAG BRACE SHAFT	1620-00-785-6873	3611500-101	451-73-3
MONR	COOP	16296A	-6	H-3 MLG	STRUT ASSY	1620-00-482-1247	56127-50102-4	451-72-3
MONR	COOP	16297A	-6	CH-3 MLG	STRUT ASSY	1620-01-037-4639	56127-50501-4	452-50-3
JENS	RIGB	16298A		F-15 C & D	BRAKE HOUSING	1630-01-065-9469	2006006	481-2-1173
MONR	ANDE	16301A	-6	F-4 MLG	STRUT ASSY R/H DRY	1620-00-919-6846	53-41400-302	451-71-3
MONR	ANDE	16302A	-6	F-4 MLG	STRUT ASSY L/H DRY	1620-00-919-6847	53-41400-301	451-71-3
COOP	COOP	16315A		F-16 MLG	AXLE L/H	1620-01-071-0535	2006035-103	451-109-3
MART	SHEL	16328A		F-15	DRUM ASSY	1005-01-042-9746	205F481	11W1-7-15-4
MART	SHEL	16331A			ENTRANCE UNIT ASSY	1005-00-397-7834	109F322	11W1-29-9-283
COOP	COOP	16334A		F-16 MLG	AXLE R/H	1620-01-071-0537	2006035-104	451-109-3
DELE		16352A		C-7 MLG	HOUSING	1620-01-020-8650	17 OCT 08	451-81-3
JENS	PRIC	16404A	-J	C-130 MLG	WHEEL (NAVY)	1630-01-014-0656	48	NAVAIR 04-10-1
DELE		16409A	-J	C-130 MLG	BRAKE ASSY (NAVY)	1630-00-052-8403	9550402	481-2-133
DELE		16411A	-J	C-130 MLG	BRAKE ASSY (NAVY)	1630-00-075-4866LC	9541667	481-2-133
COOP	COOP	16582A		F-16 MLG	TORQUE ARM-LOWER	1620-01-071-5592	2006629-105	452-00-3
MART	SHEL	16613A		F-16	AIM ADAPTER ASSY	1440-01-050-9264AB	165301-817	11LAB-9-2
MART	SHEL	16614A		F-15	UNLOAD DRIVE ASSY	1005-00-100-6969	176F727	11W1-1-15-4
MART	SHEL	16615A		F-106	DRUM ASSY	1005-00-397-7835	109F336	11W1-29-9-283
COOP	COOP	16623A		C-141 MLG	TORQUE ARM	1620-01-114-6869	3610007-117	451-73-3
MART	SHEL	16705A		F-15	LAU 114 LAUNCHER	1440-01-114-9506AB	68A732501-1009	11W1-2-14-25-
COOP	COOP	16727A		F-16 MLG	TORQUE ARM-UPPER	1620-01-124-9157	2006629-111	452-00-3
COOP	RIGB	16734A	-J	F-111 MLG	TORQUE PLATE	1630-00-460-1727	4-52	481-2-483
COOP	POLL	16743A		C-141 MLG	DOWN LOCK BELLCRANK	1620-00-204-1208	3661100-101	452-59-3
COOP	COOP	16744A		F-111 MLG	PIN AXLE	1620-00-004-6044	12L594-7	4A4-1-113
JENS	RIGB	16776A	-J	A-37 MLG	BRAKE ASSY	1630-00-847-3731	9550404	481-2-1023
JENS	COOP	16777A		C-7A MLG	DRAG BRACE	1620-00-066-2768	5750-15	451-82-3
MONR	ANDE	16836A	-6	F-4 MLG	STRUT ASSY R/H WET	1620-00-109-4286	53-41500-1	451-71-3
MONR	ANDE	16837A	-6-J	F-4 MLG	STRUT ASSY L/H WET	1620-00-109-9287	53-41500-2	451-71-3
JENS	COOP	16915A		KC-135 MLG	TRUCK ASSY	1620-00-940-5066	1583-166A	4A4-12-23
COOP	COOP	17142A	-6-J	B-52 MLG	STRUT ASSY H/W	4620-00-139-8473	7027648-190-150	451-57-3
COOP	COOP	17143A	-6-J	B-52 MLG	STRUT ASSY H/W	1620-00-139-8474	7027648-210-170	451-57-3
JENS	COOP	17224A	-J	E-7 MLG	HOUSING	1620-00-403-8443	69F27216-02	451-81-3
JENS	COOP	17239A	-6-J	KC-135 MLG	TRUNNION	1620-00-679-3440	50-9717-22	4A4-12-23
BENT	COOP	17245A	-6-J	KC-135 MLG	DRAG BRACE	1620-00-652-5472	50-9733-1	4A4-12-23
BENT	COOP	17313A	-6-J	KC-135 MLG	TRUNNION	1620-00-651-8222	50-9717-4	4A4-12-23
BENT	COOP	17314A	-6-J	KC-135 MLG	UPPER SIDE STRUT	1620-00-306-9942	5-84011-1	4A4-12-23
BENT	COOP	17315A	-6-J	KC-135 MLG	UPPER SIDE BRACE	1620-00-306-9943	5-84011-3	4A4-12-23
COOP	TOLM	17324A	-6	F-111 MLG	STRUT ASSY-SHOCK	1620-00-300-2261	7327000-50	451-78-3
BENT	COOP	17327A	-6-J	KC-135 MLG	TRUNNION	1620-00-911-8301	50-9717-25	4A4-12-23
COOP	TOLM	17346A	-6	F-111 MLG	AXLE	1620-00-439-3651	12L10021-804	4A4-17-3
BENT	COOP	17347A	-6-J	KC-135 MLG	UPPER SIDE STRUT	1620-00-709-9371	5-84011-1	4A4-12-23
BENT	COOP	17348A	-6-J	KC-135 MLG	UPPER SIDE STRUT	1620-00-711-7771	5-84011-28	4A4-12-23
COOP	COOP	17353A	-6	F-111 MLG	STRUT ASSY	1620-00-545-9395	7430562-10	4A4-18-3
COOP	TOLM	17354A	-6	F-111 MLG	STRUT ASSY	1620-00-545-9439	7430564-10	4A4-14-3
BENT	COOP	17357A	-6-J	KC-135 MLG	BRACE ASSY	M 1620-00-741-9178	65-4829-3	45A6-5-3
COOP	COOP	17402A	-6-J	F-15 MLG	STRUT ASSY	M 1620-01-042-7002	68A450401-1013	452-73-3
BENT	COOP	17407A	-6-J	KC-135 MLG	BOLT-TRUNNION	1620-00-972-1498	50-10052-2	4A4-12-24
COOP	TOLM	17418A	-6	F-111 MLG	STRUT ASSY-SHOCK	1620-01-013-5910	7327074-90	451-78-3
BENT	COOP	17451A	-6-J	KC-135 MLG	TRUNNION	M 1620-00-651-8221	50-9717-3	4A4-12-23
COOP	TOLM	17461A	-6-J	F-106 MLG	STRUT ASSY	1620-00-592-9638	578100-505	451-32-23

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LABOR STD REVIEW 10 APR 89

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RB503

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RB506

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LABOR STD REVIEW 10, APR, 69

4:37 PM

PROD NBR	RCC	OPER NBR	TYP STD	SY	FAC	STAND HOURS	OCC FAC	FACTORED STAND HOURS
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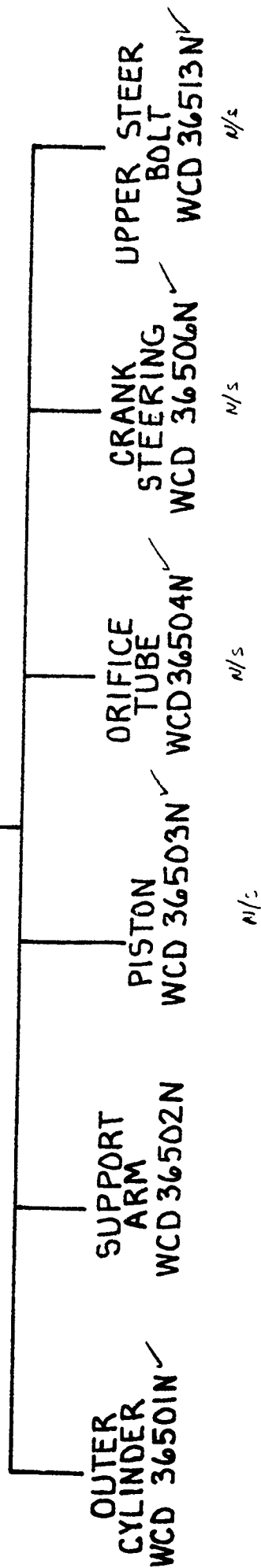
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16.00

17402A MNPWW WFS02 N WF 9 3.15 .75 2.36

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2.36-----  
81.43



F-15  
NOSE LANDING GEAR ASSY  
PCN 17402A  
WCD 36512N ✓



F-15 NLG

Assy Complete

79 operations

Dis Assy      11

106 OPER

PLATING

190 OPER

NDI

~~58~~ 58 OPER

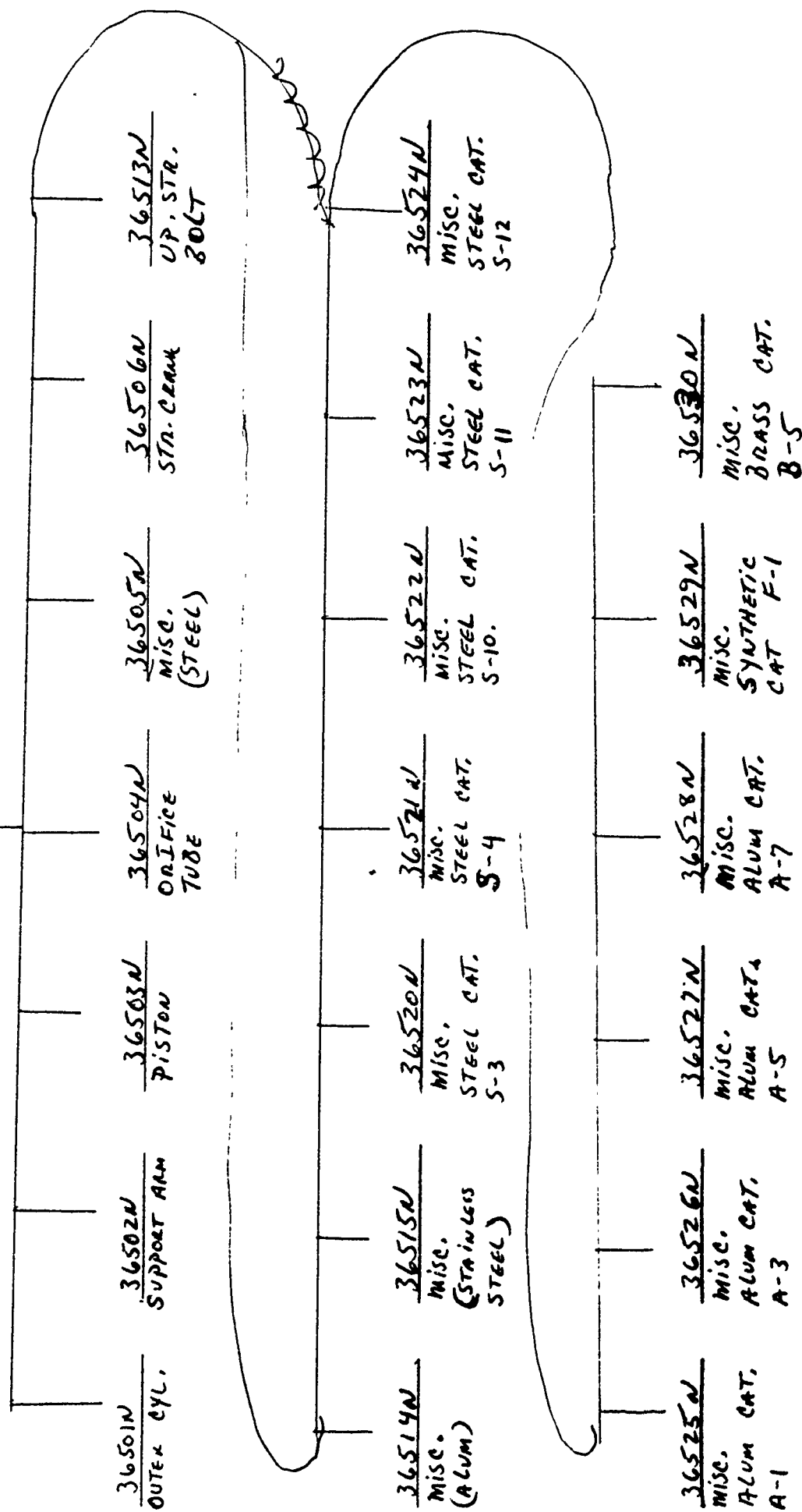
Machine/Grind

155

WELD

6 OPER

STRUT A. -  
36512N  
C/N 17402A



# F-15 NLG 02A

<u>C/N</u>	<u>WLD NAME</u>	<u>NOV</u>
17402A } 60343A }	36501N	OUTER CYL.
17402A } 68884A }	36502N	SUPPORT ARM (BRONZE) I.D
17402A } 63269A }	36503N	PISTON
17402A } 17494A }	36504N	ORIFICE TUBE
17402A	36505N	MISC. (STEEL)
17402A	36506N	CRANK STEERING
17454A	36587N	UPPER TERY LINK.
69455A	<del>365</del> 36509N	UPPER BRACE ASSY
69707A	36510N	LOWER BRACE ASSY
26244A	36511N	TERY LINK LOWER
17402A	36512N *	STRUT ASSY
17402A	36513N	UPPER STEERING BOLT
17402A	36514N	MISC. (ALUM.)
174021A	36515N	MISC. (STAINLESS STEEL)
17402A	36520N	MISC. STEEL CAT. S-3
17402A	36521N	MISC. STEEL CAT. S-4
17402A	36522N	MISC. STEEL CAT. S-10
17402A	36523N	MISC. STEEL CAT. S-11
17402A	36524N	MISC. STEEL CAT. S-12
17402A	36525N	MISC. ALUM. CAT. A-1
"02A	36526N	MISC. ALUM. CAT. A-3
17402A	36527N	MISC. ALUM. CAT. A-5
17402A	36528N	" " CAT. A-7
17402A	365229N	" SYNTHETIC CAT. F-1

<u>C/N</u>	<u>WLD NAME</u>	<u>NOUN</u>
17402A	36530N	Misc. DRAGS CAT. B-5
17402A	36531N	" SS CAT. SS-2
17402A	36532N	" CAT. SS-3
17402A	36533N	" SS CAT. SS-4

ON 80/20 LIST

17402A

NET ON 80/20 LIST

26244A

69707A

69455A

17484A

63269A

68884A

60343A

## 36512N WORK CONTROL DOCUMENT (MEDS)

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2 JOB ORDER NO 17402A		3 QUANTITY		4 PRODUCTION SEC/RCC MNP GP		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER 68A450600-1013				8 TECH DATA 4S-1-182 4S2-73-3				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES F-15 NLO			11 STOCK NUMBER 1620010627002			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN STRUT ASSY			17402A			
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		GOVERNING DIRECTIVES: AFLOR 66-51 MANOI 66-3 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLOR FORM 958. THE APPLIC- ABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REDDI* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	68A450600-1013							
34A		MATCH-UP **ROUTED COMPONENTS** NEW REWORKED NO SERVICABLE 958 REWORK					001 MNP GP 002 06 003 MU01		
		OUTER CYL / / 36501N (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				C			
		B				D			
						36512N			
						223			

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCT/SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN STPUT ASSY						
15 DISPATCH STATION	16 PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18 MECHANIC	19.	20.	
		SUPPORT ARM /							
		36502N							
		PISTON /							
		36503N							
		ORIFICE TUBE /							
		36504N							
		MISC. (STEEL) /							
		36505N							
		STR. CRANK /							
		36506N							
		UP STR BOLT /							
		36510N							
		MISC. (ALUM) /							
		36514N							
		MISC. (STAINLESS STEEL) /							
		36515N							
		MISC STEEL CAT S-3 /							
		36520N							
		MISC STEEL CAT S-4 /							
		36521N							
		MISC STEEL CAT S-10 /							
		36522N							
		MISC STEEL CAT S-11 /							
		36523N							
		MISC STEEL CAT S-12 /							
		36524N							
		MISC ALUM CAT A-1 /							
		36525N							
		MISC ALUM CAT A-3 /							
		36526N							
		MISC ALUM CAT A-5 /							
		36527N							
		MISC ALUM CAT A-7 /							
		36528N							
		MISC SYNTHETIC CAT F-1 /							
		36529N							
		MISC BRASS CAT B-5 /							
		36530N							
						*C/P MOVE			
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		36512N			
		B		D					



## 36512N WORK CONTROL DOCUMENT (MEDS)

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN STRUT ASSY						
15. DISPATCH STATION	16 PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18 MECHANIC	19. P	20. "Q"	
34A	[REDACTED] *REQD*	PRE ASSY CLEANING INSPECTION CHECK CAVITIES & INTERIOR FOR FOREIGN MATERIAL PRIOR TO REASSEMBLE *C/P MOVE				5	001 MNP GP 002 06 003 SA03		
34A	[REDACTED] *REQD*	OK TO CLOSE AND/OR ASSEMBLE *C/P MOVE				2.4	001 MNP GP 002 06 003 SA03		
34A	[REDACTED] *REQD*	CAM ALIGNMENT *C/P MOVE					001 MNP GP 002 06 003 SA03		
34A	[REDACTED] *REQD*	CHECK STROKE JAW T.O. *C/P MOVE					001 MNP GP 002 06 003 SA03		
34A	[REDACTED] *REQD*	SAFETY WIRE AS REQUIRED. JAW T.O. 452-73-3 *C/P MOVE				20	001 MNP GP 002 06 003 SA03		
34A	[REDACTED] *REQD*	TIGHTEN, TORQUE NUTS & BOLTS JAW T.O. 452-73-3 PG 8-5 *C/P MOVE				20	001 MNP GP 002 06 003 SA03		
34T	[REDACTED] *REQD*	PRESSURE TEST *C/P MOVE					001 MNP GP 002 06 003 TL07		
34P	[REDACTED] *REQD*	MASK, PRIME AND PAINT *C/P MOVE **NOTE** CHECK OPERATION NUMBERS 450 AND 460 ON PISTON WCD 958 FOR COLOR OF BANDS					001 MNP GP 002 09 003 WB03		
34P	[REDACTED] *REQD*	DECALS *C/P MOVE					001 MNP GP 002 09 003 WB03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		36512N			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN STRUT ASSY						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
34P		PROTECTIVE MASK ALL EXPOSED THREADED SURFACES *C/P MOVE					001 MNRGP 002 09 003 WR03		
34P		FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					001 MNRGP 002 09 003 WR03		
34P		FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					001 MNRGP 002 09 003 WR03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36512N			
		B		D					

## 36501N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89039

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC MNPRA		5 DATE SCHED		6 DATE COMPLETE	
7 PART NUMBER				8 TECH DATA 4S-1-182 4S2-73-3 & -4				9 ITEM SERIAL N	
10 MODEL-DESIGN-SERIES F 15 NLG			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OUTER CYLINDER			17402 A			
15 DISPATCH STATION P-N		16 PERF RCC/OP NO		17 WORK TO BE ACCOMPLISHED NSN C7R				18 MECHANIC	
68A450602-1001				1620003109830 17402A					
68A450602-1001				1620003109830 60343A					
				UNIT COST: 42704.13 *****					
				GOVERNING DIRECTIVES: AFMOR 66-51 MANC: 66-3					
				FPI IAW MIL-STD-6846					
				STRIP IAW MIL-STD-871					
				SHOT PLEN IAW MIL-S-13165					
				ANODIZE IAW MIL-A-8625					
				BRUSH ANODIZE IAW MIL-STD-865					
				BLAST IAW MIL-STD-1504					
				*****ALUMINUM*****					
				ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O. S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.					
				*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.					
				WARNING					
				MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO INEXPERIENCED PERSONNEL. ADEQUATE SAFEGUARDS & PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.					
				(CONTINUED)					
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH		FUNCTIONAL CODE		A		C		36501N	
				B		D			

\* U.S. GOVERNMENT PRINTING OFFICE: 1988-046-180

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	68A450402 1001							
	005 *REQD*	DISASSEMBLE *C/P MOVE						001 MNP GW 002 02 003 LG02 005 X8745194	
33C	007 *REQD*	CHEM CLEAN *C/P MOVE						001 MNP GW 002 03 003 AC02	
33B	009 *REQD*	BLAST CLEAN ONLY *C/P MOVE						001 MNP GW 002 03 003 BL01	
	*REQD*	*C/P MOVE				M		001 MNP PA 002 05 003 ZY05	
34E	040 *REQD*	E & I INSPECTION DRAG BRACE BUSHINGS I.D. .8750/.8760/.8780						001 MNP GW 002 04 003 EI01	
		FACE TO FACE .880/.887/REP AT .905 FLANGE THICKNESS MIN .050							
		UPPER JURY BRACE BUSHING I.D. .8440/.8450/.8470							
		FACE TO FACE 2.295/2.302/REP AT 2.316							
		FLANGE .039/.040 MIN .032							
		LOWER SUPPORT ARM BUSHINGS I.D. .7500/.7510/.7530 (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		36501N			
		B		D					

★ U.S. GOVERNMENT PRINTING OFFICE: 1989-046-100

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15 DISPATCH STATION	16 PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20. "Q"	
		FACE TO FACE .880/.887/.905 REPLACE AT .942 FLANGE .039/.040 MIN .032							
		UPPER SUPPORT ARM BUSHINGS I.D. .9995/1.0005/1.0010 FACE TO FACE 2.170/2.176/REP 2.190 FLANGE .039/.040 MIN .032							
		ORIFICE HOLE BUSHINGS I.D. 1.9910/1.9930/1.9950 WEAR 1.997							
		TRUNNION SOCKET BUSHINGS I.D. 1.1250/1.1260/1.1280							
		FACE TO FACE 15.366/15.372/REP AT 15.356 FLANGE .059/.060 MIN .052							
		DOOR LINK BUSHINGS I.D. .2500/.2510/.2530  TIE DOWN LUGS .477/.438							
		FACE TO FACE 2.093/2.138/REP 2.168 FLANGE .060/.062 LOWER BORE ID 4.244/4.246/4.253 MAX UPPER BORE I.D. 4.0000/4.0020/4.0070 MAX.							
		*****N O T E***** 100% INSPECTION IS REQUIRED OF NLG OUTER CYLINDER, P/N 68A450602-1001. INSPECT TRUNNION SOCKET WALL THICK- NESS TO INSURE THAT THEY MEET THE DIMENSIONAL REQUIREMENTS OF DRAWING NO. 68A450602. WALL THICKNESS WITH BUSH. .748+- .020, WITHOUT BUSH. .675+- .020. UNITS WITH SOCKET WALL (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		36501N			
		B		D					

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 "Q"	
		TOO THICK WILL REQUIRE ENGINEERING ASSISTANCE. ***** NOTE: IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL FPJ MUST BE PERFORMED. *C/P MOVE							
69 ✓	045	BUSHING REMOVAL *C/P MOVE						001 MNPRRA 002 03 003 BE01	
69 ✓	048	O/S ORIFICE TUBE SUPPORT BUSHING SOCKET MAX REWORK DIA 2.251						001 MNPRRA 002 03 003 MH04	
69 ✓	050	ORIFICE TUBE HOLE REPAIR OVERSIZE 2.052/2.112 MACHINE AS REQUIRED MIN 2.052 MAX 2.112 *C/P MOVE						001 MNPRRA 002 03 003 MH04	
69 ✓	051	LOWER DRAG BRACE BUSHING REPAIR O/S MACHINE LUG O/S 1.064 MAX *C/P MOVE						001 MNPRRA 002 03 003 BE01	
69 ✓	052	TIE DOWN LUGS 2 PLACES BUSHING REPAIR O/S MACHINE LUGS O/S .626 MAX *C/P MOVE						001 MNPRRA 002 03 003 BE01	
69 ✓	053	DOOR LINK LUG O/S REPAIR MACHINE LUG O/S .4385 MAX *C/P MOVE						001 MNPRRA 002 03 003 BE01	
69 ✓	054	SUPPORT ARM LOWER LUG O/S REPAIR MACHINE LUG O/S .939 MAX *C/P MOVE						001 MNPRRA 002 03 003 BE01	
69 ✓	055	SUPPORT ARM UPPER LUG O/S REPAIR MACHINE LUG O/S 1.189 MAX *C/P MOVE						001 MNPRRA 002 03 003 BE01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36501N			
		B		D					

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES				11 STOCK NUMBER		12 OPTIONAL			
13 SERIAL NUMBER				14 NOUN OUTER CYLINDER					
15 DISPATCH STATION	16 PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20. Q	
69 ✓	056	UPPER JURY BRACE LUG O/S REPAIR MACHINE LUG O/S .970 MAX *C/P MOVE						001 MNPRH 002 03 003 MH04	
69 ✓	057	TRUNNION SOCKET O/S REPAIR MACHINE LUGS O/S 1.314 MAX *C/P MOVE						001 MNPRH 002 03 003 BE01	
69 ✓	058	MACH MOUNTING HOLE O/S .263 MAX 1.0 *C/P MOVE  ***** NOTE ***** DO NOT STRIP ORIFICE TUNE HOLE						001 MNPRH 002 03 003 MH04	
26 ✓	059	STRIP TYPE 11 ANODIZE U.D. *C/P MOVE						001 MNPRC 002 03 003 AN04	
26 ✓	070	STRIP ANODIZE UPPER BORE *C/P MOVE						001 MNPRC 002 03 003 AN04	
26 ✓	080	STRIP ANODIZE LOWER BORE *C/P MOVE						001 MNPRC 002 03 003 AN04	
		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NOI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *****				M		001 MNPRH 002 06 003 ZA02	
8	099	POLISH UPPER BORE 4.010 MAX						001 MNPRB 002 01 003 BE01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36501N			
		B		D					

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15 DISPATCH STATION	16 PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18 MECHANIC	19. P	20 Q	
8 ✓	100	HONE UPPER BORE 4.010 MAX *C/P MOVE					001 MNPRB 002 01 003 HV02 005 XB745245		
8 ✓	101	POLISH LOWER BORE 4.247/4.255 O/S FOR HARD ANODIZE TYPE III					001 MNPRB 002 01 003 BE01		
8 ✓	102	HONE LOWER BORE 4.247/4.255 O/S FOR HARD ANODIZE TYPE III *C/P MOVE					001 MNPRB 002 01 003 HV02 005 XB745245		
26 ✓	104	VAPOR DEGREASE *C/P MOVE					001 MNPRC 002 03 003 0001		
26 ✓	105	GLASS BEAD THREADS ONLY .004/.008A *C/P MOVE					001 MNPRC 002 01 003 BL03		
26 ✓	110	SHOT PEEN ALL REWORKED AREAS ON 200% 4A TO 10A DO NOT SHOT PEEN AREAS AS PORTS, SEAT GROOVES ETC. *C/P MOVE					001 MNPRC 002 01 003 SP01		
26 ✓	120	SHOT PEEN UPPER BORE I.D. 200% 4A TO 10A DO NOT SHOT PEEN AREAS AS PORTS, SEAT GROOVES, ETC. *C/P MOVE					001 MNPRC 002 01 003 SP01		
26 ✓	125	SHOT PEEN LOWER BORE 200% 4A TO 10A *C/P MOVE					001 MNPRC 002 01 003 SP01		
26 ✓	130	SHOT PEEN OVERSIZED ORIFICE TUBE HOLE 200% 4A TO 10A DO NOT SHOT PEEN AREAS AS PORTS, SEAT GROOVES ETC *C/P MOVE					001 MNPRC 002 01 003 SP01		
26 ✓	135	ANODIZE OD TYPE II CLASS I *C/P MOVE					001 MNPRC 002 03 003 AS03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		36501N			
		B		D					



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2 JOB ORDER NO		3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED	
7 PART NUMBER			8. TECH DATA		9. ITEM SERIAL NO.	
10 MODEL DESIGN SERIES		11 STOCK NUMBER		12 OPTIONAL		
13 SERIAL NUMBER		14 NOLN OUTER CYLINDER				
15 DISPATCH STATION	16 PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED		18 MECHANIC	19. "P"	20. "Q"
26	138	ANODIZE ORIFICE TUBE HOLE IF ITS BEEN REWORKED TYPE II CLASS I *C/P MOVE			001 MNPRC 002 03 003 A503	
8	140	POLISH UPPER BORE AFTER SHOT SHOT PEEN 32RMS NOT TO EXCEED 4.010 PRODUCTION COUNT A6020 *C/P MOVE			001 MNPRB 002 01 003 BE01	
8	145	POLISH LOWER BORE AFTER SHOT PEEN. 32 R.M.S., NOT TO EXCEED 4.255 *C/P MOVE			001 MNPRB 002 01 003 BE01	
26	160	ANODIZE UPPER BORE TYPE III 4.000/4.004 *C/P MOVE			001 MNPRC 002 03 003 AH01 008 AJ010	
26	175	2ND REPAIR HARD ANODIZE TYPE III LOWER BORE 4.244/4.246 NOT TO EXCEED 4.253 *C/P MOVE			001 MNPRC 002 03 01 YH01 0. AI020	
8	177	FINAL POLISH UPPER BORE 4.000/4.002 32 RMS *C/P MOVE			001 MNPRB 002 01 003 BE01	
8	179	FINAL POLISH LOWER BORE 4.244/4.245/4.253 32 RMS *C/P MOVE			001 MNPRB 002 01 003 BE01	
26BP	180	BRUSH ANODIZE ORIFICE TUBE HOLE AS PER T.O. *C/P MOVE			001 MNPRC 002 02 003 BP01	
26	182	ALDINE REWORK AREAS IAW MIL-C-5541			001 MNPRC 002 03 003 TA01	
69	184	MACHINE MOUNTING BUSH 075 *C/P MOVE P/N 7829423-15			001 MNPRB 002 03 003 LE02	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN		
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7 PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18. MECHANIC	19. P"	20. "Q"	
69 ✓	185	MOUNTING BUSH O/S INSTALLATION FINISH I.D. .190/.200 P/N 7829423-15 PRESS FIT .0005-.0010 *C/P MOVE					001 MNPRA 002 03 003 BE01		
69 ✓	189	MACHINE DRAG BRACE BUSHING *C/P MOVE P/N ST4M130-14004					001 MNPRA 002 03 003 LE02		
69 ✓	190	DRAG BRACE BUSHINGS INSTALLATION P/N ST4M130-14004 LINE REAM .87501/.8760 FACE TO FACE .880/.887 *C/P MOVE					001 MNPRA 002 03 003 BE01		
69 ✓	194	MACHINE DRAG BRACE O/S BUSHING *C/P MOVE P/N 7829424-35					001 MNPRA 002 03 003 LE02		
69 ✓	195	DRAG BRACE O/S BUSHING INSTALLATION LINE REAM TO .875/.876 64RMS FACE TO FACE .880/.887 PRESS FIT .0010-.0025 P/N 7829424-35 *C/P MOVE					001 MNPRA 002 03 003 BE01		
69 ✓	199	MACHINE UPPER JURY BRACE BUSHING *C/P MOVE P/N ST4M130-14003					001 MNPRA 002 03 003 LE02		
69 ✓	200	UPPER JURY BRACE BUSH INSTALLATION P/N ST4M130-14003 LINE REAM .84401/.8450 FACE TO FACE 2.295/2.302 *C/P MOVE					001 MNPRA 002 03 003 BE01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
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7. PART NUMBER				8 TECH DATA				9. ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15 DISPATCH STATION	16 PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18 MECHANIC	19. "P"	20. "Q"	
69 ✓	204	MACHINE UPPER JURY BRACE O/S/ BUSH *C/P MOVE P/N 7829424-23					001 MNFRA 002 03 003 LE02		
69 ✓	205	UPPER JURY BRACE O/S BUSHING INSTALLATION LINE REAM .844/.845 64 RMS FACE TO FACE 2.295/2.302 PRESS FIT .0005-.0015 P/N 7829424-23 *C/P MOVE					001 MNFRA 002 03 003 BE01		
69 ✓	219	MACHINE UPPER SUPPORT ARM BUSH *C/P MOVE P/N ST4M130-16002					001 MNFRA 002 03 003 LE02		
69 ✓	220	UPPER SUPPORT ARM BUSH INSTALLATION P/N ST4M130-16002 FINISH I.D. .9995/1.0005 FACE TO FACE 2.170/2.176 *C/P MOVE					001 MNFRA 002 03 003 BE01		
69 ✓	224	MACHINE SUPPORT ARM UPPER LUG O/S BUSHING *C/P MOVE P/N 7829424-25					001 MNFRA 002 03 003 LE02		
69 ✓	225	SUPPORT ARM UPPER LUG O/S BUSHING INSTALLATION LINE REAM .9995/1.0005 64 RMS FACE TO FACE 2.170/2.176 PRESS FIT .0010-.0025 P/N 7829424-25 *C/P MOVE					001 MNFRA 002 03 003 BE01		
69 ✓	229	MACHINE LOWER SUPPORT ARM BUSHING *C/P MOVE P/N ST4M130-12007					001 MNFRA 002 03 003 LE02		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
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7 PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15 DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
69 ✓	230	LOWER SUPPORT ARM BUSH INSTALLATION P/N ST4M130-12007 FINISH I.D. .7500/.7510 FACE TO FACE .956/.962 *C/P MOVE					001 MNFRA 002 03 003 BE01		
69 ✓	234	MACHINE SUPPORT ARM LOWER LUG O/S BUSHING *C/P MOVE P/N 7829424-27					001 MNFRA 002 03 003 LE02		
69 ✓	235	SUPPORT ARM LOWER LUG O/S BUSHING INSTALLATION LINE REAM .750/.751 64 RMS FACE TO FACE .956/.962 PRESS FIT .0005-.0010 P/N 7829424-27 *C/P MOVE					001 MNFRA 002 03 003 BE01		
69 ✓	239	MACHINE DOOR LINK BUSHING *C/P MOVE P/N ST4M130-04001					001 MNFRA 002 03 003 LE02		
69 ✓	240	DOOR LINK BUSHING INSTALLATION P/N ST4M130-04001 FINISH ID .2500/.2510 *C/P MOVE					001 MNFRA 002 03 003 BE01		
69 ✓	244	MACHINE DOOR LINK LUG O/S BUSHING *C/P MOVE P/N 7829424-33					001 MNFRA 002 03 003 LE02		
69 ✓	245	DOOR LINK LUG O/S BUSH INSTALLATION LINE REAM TO .250/.251 64 RMS P/N 7829424-33 PRESS FIT .0005-.0010 *C/P MOVE					001 MNFRA 002 03 003 BE01		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15. DISPATCH STATION	16 PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
69 ✓	249	MACHINE TRUNNION SOCKET BUSHING *C/P MOVE P/N 68A450631-2001					001 MNHRA 002 03 003 LE02		
69 ✓	250	TRUNNION SOCKET BUSH INSTALLATION P/N 68A450631-2001 FINISH I.D. 1.1250/1.1260 FACE TO FACE 15.366/15.372 *C/P MOVE					001 MNHRA 002 03 003 BE01		
69 ✓	254	MACHINE TRUNNION SOCKET O/S BUSH *C/P MOVE P/N 7829420-1					001 MNHRA 002 03 003 LE02		
69 ✓	255	TRUNNION SOCKET O/S BUSHING INSTALLATION LINE REAM 1.125/1.126 FACE TO FACE 15.366/15.372 PRESS FIT .0010-.0025 P/N 7829420-1 *C/P MOVE					001 MNHRA 002 03 003 BE01		
69 ✓	259	MACHINE TIE DOWN LUGS BUSHING *C/P MOVE P/N ST4M139P7-44					001 MNHRA 002 03 003 LE02		
69 ✓	260	TIE DOWN LUGS BUSHING INSTALLATION P/N ST4M139P7-44 FINISH ID .437/.438 FACE TO FACE 2.093/2.133 PRODUCTION COUNT B0020 *C/P MOVE					001 MNHRA 002 03 003 BE01		
69 ✓	264	MACHINE TIE DOWN LUG O/S BUSHING *C/P MOVE P/N 7829424-31					001 MNHRA 002 03 003 LE02		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT NO.			
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7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL/DESIGN/SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
69 ✓	265	TIE DOWN LUG O/S BUSH INSTALLATION 2 PLACES LINE REAM TO .562/.563 64 RMS FACE TO FACE 2.093/2.138 PRESS FIT .0005-.0010 P/N 7829424-31 *C/P MOVE					001 MNRRA 002 03 003 BE01		
69 ✓	279	MACHINE ORIFICE TUBE HOLE BUSH *C/P MOVE P/N 8412725-01 P/N 2-033N674					001 MNRRA 002 03 003 LE02		
69 ✓	280	ORIFICE TUBE HOLE BUSHING P/N 8412725-01 & P/N 2-033N674 INSTALLATION, LOWER FINISH I.D. 1.9920/1.9930 SHRINK FIT .0005-.0015 *C/P MOVE					001 MNRRA 002 03 003 BE01		
69 ✓	289	MACHINE ORIFICE TUBE HOLE BUSHING *C/P MOVE P/N ST4M130-24002					001 MNRRA 002 03 003 LE02		
69 ✓	290	ORIFICE TUBE HOLE BUSHING INSTAL. P/N ST4M 130-24002 FINISH ID 1.9920/1.9930 SHRINK FIT .0005-.0015 *C/P MOVE					001 MNRRA 002 03 003 BE01		
69 ✓	294	MACHINE ORIFICE TUBE HOLE O/S BUSHING *C/P MOVE P/N 7829424-91					001 MNRRA 002 03 003 LE02		
69	295	ORIFICE TUBE HOLE BUSHING INSTALL O/S FINISH I.D. 1.9920/1.9930 *C/P MOVE P/N 7829424-91					001 MNRRA 002 03 003 BE01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
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7. PART NUMBER				8 TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13. SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15 DISPATCH STATION	16. PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19. "P"	20 "Q"	
	297	PAINT *C/P MOVE					001 MNR GP		
							002 09		
							003 WB03		
	298	DECAL *C/P MOVE					001 MNR GP		
							002 09		
							003 WB03		
	300	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					001 MNR GP		
	*REQD						002 06		
							003 SA03		
	310	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					001 MNR GP		
	*REQD						002 06		
							003 SA03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		36501N			
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2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC MNP GP		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA 4S-1-182 4S2-73-3 & -4				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES F-15 NLG			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN SUPPORT ARM (BRONZE) I.D.			17402A			
15. DISPATCH STATION P7N 68A450	16. PERF RCC/OP NO 53-1001	17. WORK TO BE ACCOMPLISHED NSN C7N 1620003051726 17402A 68884A				18. MECHANIC	19. "P"	20. "Q"	
		***** UNIT COST: 1542.02 *****							
		GOVERNING DIRECTIVES: AFLCR 66-51 MANUT 66-3							
		FPI IAW MIL-STD-6866							
		STRIP IAW MIL-STD-871							
		ANODIZE IAW MIL-A-8625							
		ALDOLINE IAW MIL-C-5541							
		BLAST IAW MIL-SID-1504							
		FLAME SPRAY IAW MIL-STD-869							
		*****ALUMINUM*****							
		ALL PERSONNEL INVOLVED IN THE WORK							
		PROCESSES SPECIFIED IN THIS DOCUMENT							
		HAVE BEEN THOROUGHLY TRAINED AND ARE							
		FAMILIAR WITH ALL PERTINENT SAFETY							
		PRACTICES AND HAZARDS CONTAINED IN							
		THE BASIC TECHNICAL ORDER (T.O.) AND							
		T.O. SUPPLEMENTS REFERENCED. THE							
		APPLICABLE T.O.'S AND SUPPLEMENTS							
		WILL ALWAYS BE USED IN CONJUNCTION							
		WITH THIS DOCUMENT.							
		*COMPONENTS WILL BE THOROUGHLY							
		CLEANED & PROTECTED (C/P MOVE) FOR							
		MOVES BETWEEN OPERATIONS/DISPATCH							
		STATIONS.							
		WARNING							
		MANY OF THE FOLLOWING REPAIR							
		PROCEDURES REQUIRE THE USE OF							
		EQUIPMENT, PROCESSES & CHEMICALS							
		WHICH ARE POTENTIALLY DANGEROUS TO							
		INEXPERIENCED PERSONNEL. ADEQUATE							
		SAFEGUARDS & PRECAUTIONS MUST BE							
		EMPLOYED TO PRECLUDE INJURIES.							
(CONTINUED)									
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13. SERIAL NUMBER			14 NOUN SUPPORT ARM (BRONZE) I.D.						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	68A450653-1001							
	005	DISASSEMBLE						001 MNP GW	
	*REQD*							002 02	
								003 L802	
								005 X8745199	
	007	CHEM CLEAN						001 MNP GW	
	*REQD*							002 03	
								003 AC02	
	009	BLAST CLEAN ONLY						001 MNP GW	
	*REQD*							002 03	
								003 BL07	
								001 MNP NA	
	*REQD*					M		002 05	
								003 ZY05	
	020	E & I INSPECTION						001 MNP GW	
	*REQD*	UPPER BEARING I.D.						002 04	
		2.4995/2.5010/2.5040/2.5400						003 E101	
		LOWER BEARING I.D.							
		1.8745/1.8760/1.8790							
		SUPPORT ARM UPPER BOLT HOLE I.D.							
		1.0000/1.0010/1.0030							
		SUPPORT ARM LOWER BOLT HOLE I.D.							
		.75007/.75107/.7530							
		OVERALL 4.107/4.113							
		(CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN SUPPORT ARM (BRONZE) I.D.						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		NOTE: IF SUPPORT ARM HAS BLACK FABROID COATING, ROUTE TO MACHINE SHOP FOR FLAME SPRAY: REIDENTIFY USING P/N 68A450653-1001 *C/P MOVE							
26 ✓	021	STRIP ANODIZE *C/P MOVE*						001 MNPRC 002 03 003 AN04	
69 ✓	022	O/S LOWER BOLT HOLE .814 MAX AS REQUIRED ONLY TO REMOVE CORROSION *C/P MOVE						001 MNPRC 002 02 003 MH06	
69 ✓	023	MACHINE LOG FACES TO REMOVE CORROSION IAW AF DWG. 856003 1.0255/1.0305 FACE TO FACE * C/P MOVE						001 MNPRC 002 02 003 MV00	
69 ✓	024	O/S UPPER BOLT HOLE 1.120 MAX. AS REQ'D ONLY TO REMOVE CORROSION * C/P MOVE						001 MNPRC 002 02 003 MH06	
26 ✓	025	VAPOR DECREASE *C/P MOVE						001 MNPRC 002 03 003 DG01	
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****				M		001 MNPRC 002 06 003 ZA02	
26 ✓	028	ANODIZE TYPE II CLASS I NOTE: MASK OFF UPPER AND LOWER BEARING I.D.'S AND LIPS (CONTINUED)						001 MNPRC 002 03 003 AS03	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
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7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN SUPPORT ARM (BRONZE) I.D.						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*C/P MOVE							
69 ✓	029	MACHINE O/S BUSHING P/N 7829423-21 P/N 7829424-95 *C/P MOVE					001 MNFRA 002 02 003 LE02		
69 ✓	030	INSTALL FLANGED BUSHING IF OPERATION 023 COMPLETED P/N 7829424-95 I.D. .750/.751 32 PMS FACE TO FACE .9655/.9680/.9705 PRESS FIT .0005-.0020 *C/P MOVE					001 MNFRA 002 02 003 BE01		
69 ✓	032	INSTALL O/S BUSHING 7829423-21 ID .750/.751 FIT AT .0005/.0015 *C/P MOVE					001 MNFRA 002 02 003 BE01		
69 ✓	034	MACHINE O/S BUSHING P/N 7829423---35 *C/P MOVE					001 MNFRA 002 02 003 LE02		
69 ✓	036	INSTALL O/S BUSHING 7829423-35 I.D. 1.000/1.001 FIT AT .0005/.0020 *C/P MOVE					001 MNFRA 002 02 003 RE01		
69 ✓	037	MACHINE UPPER LIP FOR FLAME SPRAY IAW MCDONNELL PRINT 68A450653 *C/P MOVE					001 MNFRA 002 02 003 LE02 005 X8633612		
69 ✓	038	MACHINE 45 DEGREE CHAMFER ON UPPER LIP FOR FLAME SPRAY IAW PRINT 68A450653					001 MNFRA 002 02 003 LE02 005 X8633612		
69 ✓	040	MACHINE LOWER LIP FOR FLAME SPRAY IAW MCDONNELL PRINT 68A450653 *C/P MOVE					001 MNFRA 002 03 003 MV00 005 X8633613		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
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7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN SUPPORT ARM (BRONZE) I.D.						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
69 ✓	050	OVERSIZE UPPER BEARING ID FOR FLAME SPRAY MAX 2.528/2.518 MIN *C/P MOVE						001 MNPRA 002 02 003 LE02 005 X8633612	
69 ✓	060	OVERSIZE LOWER BEARING ID FOR FLAME SPRAY MAX 1.903/1.893 *C/P MOVE						001 MNPRA 002 02 003 LE02 005 X8633612	
		[REDACTED] TO FLAME SPRAY *C/P MOVE						001 MNPWW 002 08 003 DG02	
		[REDACTED] AREAS PRIOR TO FLAME SPRAY *C/P MOVE						001 MNPWW 002 08 003 BL01	
		[REDACTED] BEARING SUFFICIENT TO MACHINE TO 2.4995/2.5015 IAW MCDONNELL PRINT 68A450653 *C/P MOVE						001 MNPWW 002 08 003 FS12 005 X8929483	
		[REDACTED] BEARING SUFFICIENT TO MACHINE TO 1.8745/1.8765 IAW MCDONNELL PRINT 68A450653 *C/P MOVE						001 MNPWW 002 08 003 FS12 005 X8929483	
		[REDACTED] R LIP IAW MCDONNELL PRINT 68A450653 *C/P MOVE						001 MNPWW 002 08 003 FS12 005 X8929483	
		[REDACTED] LIP IAW MCDONNELL PRINT 68A450653 *C/P MOVE						001 MNPWW 002 08 003 FS12	
69 ✓	140	MACHINE UPPER BEARING I.D. 2.4995/2.5015 *C/P MOVE NOTE: REF FIG 9-4 FOR ALLOW LIMITS ON FLAME SPRAY						001 MNPRA 002 02 003 LE02 005 X8633618	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
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7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN SUPPORT ARM (BRONZE) I.D.						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
69 J	150	MACHINE LOWER BEARING I.D. 1.8745/1.8765 *C/P MOVE					001 MNPRN	002 02	
							003 LE02	005 X8633612	
69 J	160	MACHINE UPPER LIP IAW MCDONNELL PRINT 68A450653 *C/P MOVE					001 MNPRN	002 02	
							003 LE02	005 X8633612	
69 J	165	MACHINE 45 DEGREE CHAMFER ON UPPER LIP IAW PRINT 68A450653					001 MNPRN	002 02	
							003 LE02	005 X8633612	
69 J	170	MACHINE LOWER LIP IAW MCDONNELL PRINT 68A450653 *C/P MOVE					001 MNPRN	002 02	
							003 HV00	005 X8633612	
69 J	180	DRILL HOLE FOR NASS16-1 FITTING IAW MCDONNELL PRINT 68A450653 *C/P MOVE					001 MNPRN	002 02	
							003 BE01		
69 J	181	REIDENTIFY TO 68A450653-1001 *C/P MOVE					001 MNPRN	002 03	
							003 BE01		
23 E.V.	183	SPOT ALUMINE ONLY *C/P MOVE					001 MNPRN	002 03	
							003 TA01		
34P		MASK, PRIME AND PAINT *C/P MOVE					001 MNPRN	002 09	
							003 WB03		
34P		DECAL *C/P MOVE					001 MNPRN	002 09	
							003 WB03		
34P		FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958					001 MNPRN	002 09	
							003 WB03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36502N			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8. TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN SUPPORT ARM (BRONZE) I.O.						
15 DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
JFF		FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					001 RNP CP		
	*REQD*						002 09		
							003 WB03		
21 FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		36502N			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC MNPGR		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA 4S2-73-3 & -4 4S-1-182				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES F 15 NLG			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN PISTON			17402A			
15 DISPATCH STATION P/N 68A450	16 PERF RCC/OP NO 704-1003	17 WORK TO BE ACCOMPLISHED NSN C/N 1620010232138 17402A 63269A				18 MECHANIC	19 "P"	20 "Q"	
		***** UNIT COST: \$15625.10 *****							
		GOVERNING DIRECTIVES: AFMCR 66-51 MAN01 66-3							
		100 ALUM PLATE IAW MIL-C-83488A							
		FPI IAW MIL-STD-6866							
		FMPI IAW MIL-STD-1949							
		P/O NO1561							
		STRIP IAW MIL-STD-871							
		TEMPER ETCH IAW MIL-STD-867							
		SHOT PEEN IAW MIL-S-13165							
		CHROME PLATE IAW MIL-STD-150							
		BAKE IAW 4S-1-182							
		MA01 74-12							
		BLAST IAW MIL-STD-1504							
		ALODINE IAW MIL-C-5541							
		***** T A E L 280,000/300 000 PSI*****							
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.							
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		WARNING							
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS (CONTINUED)							

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	36503N	
		B	D		

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN PISTON						
15. DISPATCH STATION	16. PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	68A4507, 4-1003							
	005	DISASSEMBLE *C/P MOVE					001 MNP GW		
	*REQD*						002 02		
							003 1 002		
							005 X 243 99		
	007	CHRM CLAS *C/P MOVE					001 MNP GW		
	*REQD*						002 03		
							003 SI 01		
	009	BLAST ID OF FORK AND H*LL AREA WITH PLASTIC BEAD OR WALNUT SHELL TO REMOVE PAINT AND CORROSION (REFER TO FIGURE 8-6)					001 MNP GW		
	*REQD*						002 03		
		*C/P MOVE					003 BL 02		
	011	BAKE 4 HRS AT 350-400F					001 MNP GW		
	*REQD*	DATE IN _____ TIME IN _____					002 03		
		DATE OUT _____ TIME OUT _____					003 BK 03		
		*C/P MOVE							
		[REDACTED] *C/P MOVE					001 MNP GW		
	*REQD*						002 05		
							003 ML 04		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		36503N			
		B		D					



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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN PISTON						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
E	000 *READY*	E 3.1 INSPECTION REF FIG 8-5 & 8-6 FOR INTERIOR, EXTERIOR REPAIR PISTON O.D. 3.495/3.497/3.492					001 MPBW 002 04 003 EI01		
		INNER WHEEL JOURNAL 2.2447/2.2466/2.2420 OUTER WHEEL JOURNAL 2.2147/2.2166/2.2120							
		OUTER AXLE I.D. 1.690/1.700 CENTER AXLE I.D. 1.940/1.960 INNER AXLE I.D. 1.550/1.570 PISTON UPLOCK ID .428/.409							
		PISTON TOE SOCKET .755/.765 I.D. PISTON I.D. 3.140/3.145 *****							
		* - - - N O T E - - - * CHECK RADIUS AS PER TECH ORDER * 1 0 0 % REQUIREMENT * RECORD SERIAL NUMBER FOR * ENGINEERING * IF MACHINING OF RADIUS IS * REQUIRED, TEMPER ETCH MUST BE * ACCOMPLISHED							
		* CHECK FURK + AXLE AREA FOR PAINT * AND CORROSION REMOVAL *****							
		***** * - - - "SPECIAL NOTE" - - - *ULTRA SONIC INSPECTION OPERATIONS * #035 AND #040 ARE NOT REQUIRED * FOR -2009 PISTONS *****							
		NOTE: IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL FMPI MUST BE PERFORMED. *C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36503N			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN PISTON							
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		TAW FIG. 6-6 MIN WALL THICKNESS .190 IN RECORD MEASUREMENT *C/P MOVE				M	001 MNR NA 002 05 003 EC04		
		AS PER T.O. CHECK WALL THICKNESS .220/.310 AS PER T.O. RECORD MEASUREMENT *C/P MOVE				M	001 MNR NA 002 05 003 EC04		
		IF .160 OR ABOVE, STA. 34P WILL PAINT A "1" INCH GREEN BAND BETWEEN JACK-PAD LUG AND PISTON AREA				M	001 MNR NA 002 05 003 EC04		
		CHECK WALL THICKNESS BELOW .160 AND ESTIMATE NUMBER OF LANDINGS LEFT IN PISTON							
		RECORD "T1" DIMENSION-----							
		RECORD "T2" DIMENSION-----							
		RECORD "T MEN" DIMENSION-----							
		RECORD "T" DIMENSION-----							
		RECORD NUMBER OF LANDINGS----- STA. 34P WILL PAINT "1" INCH YELLOW BAND BETWEEN JACK-PAD AND PISTON AREA							
		***** NOTES ***** 1-IF LESS THAN 200 LANDINGS REMAIN AFLD FORM 103 THE PISTON							
		2-IF MORE THAN 200 LANDINGS REMAIN LANDINGS ARE TO BE ANNOTATED ON THE AFTO 95 FORM							
26 ✓	044	VAPOR DECREASE				*C/P MOVE		001 MNR RC 002 03 003 DG01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36503N			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7. PART NUMBER				8 TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN PISTON						
15 DISPATCH STATION	16 PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18 MECHANIC	19. "P"	20 "Q"	
20 ✓	046	STRIP CAD *C/P MOVE					001 MNP RC	002 02 003 CS01	
26 ✓	048	STRIP ROST *C/P MOVE					001 MNP RC	002 02 003 CS02	
69 ✓	050	MACHINE RADIUS ON I.D. OF FORK IAW FIG 8-6 & DRAWING 68A450604 REMOVE X OR M FROM SER. #. *C/P MOVE					001 MNP RA	002 03 003 MH02	
69 ✓	060	POLISH RADIUS ON I.D. OF FORK IAW FIG 8-6. *C/P MOVE					001 MNP RA	002 03 003 BE01	
8 ✓	065	POLISH OUTER AXLE I.D. 1.680/1.700 *C/P MOVE+ 63RMS					001 MNP RB	002 01 003 BE01	
8 ✓	070	POLISH INNER AXLE I.D. 1.940/1.960 *C/P MOVE+ 63RMS					001 MNP RB	002 01 003 BE01	
8 ✓	075	POLISH INNER AXLE I.D. 1.550/1.570 *C/P MOVE 63RMS					001 MNP RB	002 01 003 BE01	
		IAW FIG. 8-6 MIN WALL THICKNESS .190 IN *REQD* RECORD MEASUREMENT *C/P MOVE				M	001 MNP RA	002 05 003 EC04	
69 ✓	090	UNLOCK BUSHING REPAIR OVERSIZE LUG MIN. .498 TO MAX AS REQUIRED TO .564 64 RMS *C/P MOVE					001 MNP RA	002 03 003 BE01	
69 ✓	100	TOW SOCKET BUSHING REPAIR OVERSIZE LUG MIN. .9360 TO MAX. 1.00 64 RMS (CONTINUED)					001 MNP RA	002 03 003 MH04	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		36503N			
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2 JOB ORDER NO.		3. QUANTITY		4 PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN PISTON						
15 DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO & ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*C/P MOVE							
26 ✓	110	STRIP CHROME PISTON O.D. *C/P MOVE*					001 MNPRC 002 02 003 SC02		
26 ✓	112	STRIP CHROME INNER AXLE JOURNAL O.D. *C/P MOVE*					001 MNPRC 002 02 003 SC02		
26 ✓	115	STRIP CHROME OUTER AXLE JOURNAL O.D. *C/P MOVE*					001 MNPRC 002 02 003 SC02		
26 ✓	117	STRIP CHROME PISTON I.D. *C/P MOVE					001 MNPRC 002 02 003 SC02		
86 ✓	120	FIRST GRIND PISTON O.D. 3.4750 MIN *C/P MOVE					001 MNPRC 002 03 003 GG01 005 X8745186		
86 ✓	130	FIRST GRIND INNER AXLE JOURNAL O.D. MIN DIA 2.2250 *C/P MOVE					001 MNPRC 002 03 003 GG01 005 X7831922		
86 ✓	140	FIRST GRIND OUTER AXLE JOURNAL O.D. MIN DIA 2.195 *C/P MOVE					001 MNPRC 002 03 003 GG01 005 7831922		
8	145	FIRST HONE PISTON I.D. MAX. DIA 3.150 Grind *C/P MOVE					001 MNPRC 002 01 003 HV03 005 X8745246		
		DATE OUT _____ *C/P MOVE (CONTINUED)				M	001 MNPRC 002 06 003 TE03		
81. FINAL DESTINATION		82. COORDINATION/INITIATING RCC SIGNATURE/DATE				83. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		36503N			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN PISTON						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****							
26A ✓	160	BAKE 4 HRS WITHIN 8 HRS OF ETCH DATE IN _____ TIME IN _____						001 MNPRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****				M		001 MNPRC 002 06 003 HL04	
26 ✓	175	VAPOR DECREASE *C/P MOVE						001 MNPRC 002 03 003 DG01	
26 ✓	180	SHOT PEEN REWORK AREA PISTON, 200% COVERAGE 3A TO 6A *C/P MOVE						001 MNPRC 002 01 003 SP02	
26 ✓	190 *REQD*	SHOT PEEN FORK AND AXLE I.D. 200% COVERAGE 3 TO 6A INTENSITY *C/P MOVE						001 MNPRC 002 01 003 SP02	
26 ✓	200	GLASS BEAD PEEN THREADS INTENSITY 4A TO 8A *C/P MOVE						001 MNPRC 002 01 003 BL03	
26 ✓	210	SHOT PEEN INNER AXLE JOURNALS 200% COVERAGE 3A TO 6A *C/P MOVE						001 MNPRC 002 01 003 SP02	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A				C			
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						36503N			

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN PISTON						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26 ✓	220	SHOT PEEN OUTER AXLE JOURNALS 200% COVERAGE 3A TO 6A *C/P MOVE					001 MNPRC 002 01 003 SP02		
26 ✓	225	SHOTPEEN PISTON I.D. 200% COVERAGE 3A TO 6A *C/P MOVE					001 MNPRC 002 01 003 SP02		
26 ✓	227	PREPARE AXLE JOURNALS FOR CHROME PLATE CLASS III TYPE II MASK/FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED					001 MNPRC 002 02 003 BE01		
26 ✓	228	PREPARE AXLE JOURNALS FOR CHROME PLATE, GRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 BL02		
26 ✓	230	CHROME PLATE INNER AXLE JOURNAL. CLASS III TYPE II SUFFICIENT TO GRIND TO 2.2447/2.2466					001 MNPRC 002 02 003 CP01 008 CD010		
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED _____ *C/P MOVE							
26 ✓	240	CHROME PLATE OUTER AXLE JOURNAL CLASS III TYPE II SUFFICIENT TO GRIND TO 2.2147/2.2166					001 MNPRC 002 02 003 CP01 008 CD020		
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED _____ *C/P MOVE							
26B ✓	250	BAKE 4 HRS WITHIN 4 HRS OF CHROME DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36503N			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES				11 STOCK NUMBER		12 OPTIONAL			
13 SERIAL NUMBER				14 NOUN PISTON					
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
26 ✓	253	PREPARE O.D. FOR CHROME PLATE CLASS III TYPE II MASK/FIXTURE/ETC MECHANIC SIGN OFF REQUIRED *C/P MOVE					001 MNARC 002 02 003 BE01		
26 ✓	257	PREPARE PISTON O.D. FOR CHROME PLATE, GRIT BLAST *C/P MOVE					001 MNARC 002 01 003 BL02		
26 ✓	250	CHROME PLATE O.D. CLASS III TYPE II SUFFICIENT TO GRIND TO 3.495/ 3.497 DATE OUT TIME OUT MECHANIC SIGN OFF REQUIRED *C/P MOVE					001 MNARC 002 02 003 CP01 005 18343080 008 C0020		
26 ✓	270	BAKE 4 HRS AT 350-400F WITHIN 4 HRS OF CHROME. DATE & TIME DATE & TIME IN OUT *C/P MOVE					001 MNARC 002 02 003 BK01		
26 ✓	271	PREPARE PISTON I.D. FOR CHROME PLATE CLASS III TYPE II MASK/FIXTURE/ETC. MECHANIC SIGN OFF REQ'D *C/P MOVE					001 MNARC 002 02 003 BE01		
26 ✓	272	PREPARE PISTON I.D. FOR CHROME PLATE, GRIT BLAST *C/P MOVE					001 MNARC 002 01 003 BL02		
26 ✓	273	CHROME PLATE PISTON I.D. CLASS III TYPE II SUFF. TO GRIND TO 3.140/3.145 (CONTINUED)					001 MNARC 002 02 003 CP01 008 C1010		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36503N			
		B		D					

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN PISTON						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. P	20. Q	
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQ'D _____							
26B ✓	275	BAKE 23 HRS AT 350-400 F WITHIN 4 HRS OF CHROME DATE IN _____ TIME IN _____						001 MNPRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ **REQ'D AFTER FINAL CHROME PLATE OPERATION** *C/P MOVE							
8G ✓	280	FINISH GRIND INNER AXLE JOURNAL O.D. 2.2447/2.2466 *C/P MOVE						001 MNPRB 002 03 003 GG01 005 X7831922	
8G ✓	290	FINISH GRIND OUTER AXLE JOURNAL O.D. 2.2147/2.2166 *C/P MOVE						001 MNPRB 002 03 003 GG01 005 X7831922	
8G ✓	300	FINISH GRIND O.D. 3.495/3.497 16RMS *C/P MOVE						001 MNPRB 002 03 003 GG01 005 X8745186	
8 ✓	305	FINISH GRIND PISTON I.D. 3.140/3.145 32 RMS *C/P MOVE						001 MNPRB 002 02 003 GI05	
26B ✓	310	BAKE 4 HRS DATE IN _____ TIME IN _____						001 MNPRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		[REDACTED] *C/P MOVE ***** NOTE ***** (CONTINUED)				M		001 MNPRB 002 06 003 ML04	
81. FINAL DESTINATION		82. COORDINATION/INITIATING RCC SIGNATURE/DATE				83. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36503N			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIEE			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN PISTON						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20. "Q"	
		IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *****							
26 ✓	325	VAPOR DEGLAZE *C/P MOVE						001 MNPRC 002 03 003 D001	
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *****				m		001 MNPRC 002 06 003 Z501	
26 ✓	331	GRIT BLAST PISTON I.D. IAW MIL-STD-1504 *C/P MOVE						001 MNPRC 002 01 003 BL02	
26 ✓	332	GRIT BLAST AXLE I.D. IAW MIL-STD-1504 *C/P MOVE						001 MNPRC 002 01 003 BL02	
26 ✓	333	PRIOR TO CAD/VAC CAD/IVD, GRIT BLAS ALL AREAS TO BE CAD/VAC CAD/IVD PLATED *C/P MOVE						001 MNPRC 002 01 003 BL02	
26 ✓	335	VACUUM CAD PLATE TYPE II CLASS 2 OPTIONAL WHEN BUSHINGS HAVE NOT BEEN REMOVED *C/P MOVE						001 MNPRC 002 02 003 VC01	
26 ✓	340	CAD PLATE TYPE II CLASS 2 1.05 SQ FI AT 52.5 - 70.4 AMPS TIME OUT _____ DATE OUT _____ NOTE, AXLE AND FORK I.D. RECEIVES 100% SURFACE COVERAGE IAW FIG 8-6 *C/P MOVE						001 MNPRC 002 03 003 CA01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/EN			
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2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9. ITEM SERIAL NO.	
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN PISTON						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
20B ✓	320	BAKE 23 HRS WITHIN 4 HRS OF CAD DATE IN _____ TIME IN _____					001 MNP RC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
20 ✓	390	IRIDITE *C/P MOVE					001 MNP RC 002 02 003 IR01		
	-65	*C/P MOVE *****NDIE***** IF LAST MDT OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *****				M	001 MNP NA 002 06 003 ML04		
20 ✓	402	VAC IVD ALUM PLATE CLASS 2 TYPE 11 NOTE: OPERATION 275 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION. *C/P MOVE					001 MNP RC 002 03 003 IV01		
20 ✓	403	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE					001 MNP RC 002 03 003 TA01		
		[REDACTED] IAW FIG. 8-6 *REQD* MIN WALL THICKNESS .190 IN RECORD MEASUREMENT _____ *C/P MOVE				M	001 MNP NA 002 05 003 EC04		
		[REDACTED] AS PER T.O. *REQD* CHECK WALL THICKNESS .280/.310 AS PER T.O. RECORD MEASUREMENT _____ (CONTINUED)				M	001 MNP NA 002 05 003 EC04		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN PISTON						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 "Q"	
		P/C/P MOVE							
69 ✓	418	MACHINE TOWING BUSHING 63 RMS *C/P MOVE P/N STAM139P12-62						001 MNPRA 002 03 003 LE02	
69 ✓	420	TOWING BUSHING INSTALLATION *C/P MOVE* .755/.765						001 MNPRA 002 03 003 ME01	
69 ✓	429	MACHINE UPLOCK BUSHING 64 RMS *C/P MOVE P/N 7829423-11						001 MNPRA 002 03 003 LE02	
69 ✓	430	UPLOCK BUSHING INSTALLATION P/N 7829423-11 PRESS FIT .0005/.001 FINISH I.D. .438 *C/P MOVE							
69 ✓	439	MACHINE TOW SOCKET BUSHING 64 RMS *C/P MOVE P/N 7829424-21						001 MNPRA 002 03 003 LE02	
69 ✓	440	TOW SOCKET BUSHING INSTALLATION P/N 7829424-21 PRESS FIT .0005/.001 FINISH I.D. .755/.765 *C/P MOVE							
	442	PRE- PAINT PISTON *C/P MOVE*						001 MNPBP 002 09 003 PP01	
	445	ASSEMBLE NLG PISTON *C/P MOVE*						001 MNPBP 002 06 003 SA03	
	450	PAINT FORK AND AXLE IAW T.O. 452-73-3 PARA. 4-12 TO 4-16 *C/P MOVE						001 MNPBP 002 09 003 WB03	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN PISTON						
15. DISPATCH STATION	16. PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19. "P"	20. "Q"	
34P		PAINT GREEN BAND-----					001 MNFOP		
		PAINT YELLOW BAND-----					002 09		
		RC/P MOVE					003 WB03		
34P		FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					001 MNFOP		
							002 09		
							003 WB03		
34P		FINAL PRODUCT VISUAL INSPECTION RC/P MOVE					001 MNFOP		
							002 09		
							003 WB03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC MNPDP		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA 452-73-3 & -4 45-1-182				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES F 15 NLG			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN ORIFICE TUBE			17402A			
15 DISPATCH STATION P/N 68A4507	16 PERF RCC/OP NO 26-2001	17 WORK TO BE ACCOMPLISHED NSN C/N 1620003084145; 17402A 17494A				18 MECHANIC	19 "P"	20 "Q"	
		GOVERNING DIRECTIVES: AFMOR 66-51 MANOJ 66-3 IWD ALUM PLATE IAW MIL-C-83488A FPI IAW MIL-STD-6866 FMP1 IAW MIL-STD-1949 P/O NO1561 STRIP IAW MIL-STD-871 GRIND IAW MIL-STD-866							
		TEMPER ETCH IAW MIL-STD-867 SHOT PEEN IAW MIL-S-13165 CHROME IAW MIL-STD-1501 P/O N61891							
		AND/OR P/O N41321 ALDOINE IAW MIL-C-5541 VAC CHD IAW MIL-C 8637 CAP IAW MIL-STD-870							
		BAKE IAW 45-1-182 MANOJ 74-12 NICKLE PLATE IAW MIL-STD-865 BLAST IAW MIL-STD-1504							
		UNIT COST \$2298.00 STEEL 280,000/300,000							
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN ORIFICE TUBE						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19. "P"	20. "Q"	
		CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		WARNING							
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO INEXPERIENCED PERSONNEL. ADEQUATE SAFEGUARDS & PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	68A450726 2001							
<del>34C</del>	005	DISASSEMBLE *C/P MOVE					001 MNP GW		
	*REQD*						002 02		
							003 LG02		
							005 XB745199		
<del>34C</del>	007	CHEM CLEAN *C/P MOVE					001 MNP GW		
	*PEQD*						002 03		
							003 SL01		
<del>34C</del>	009	BLAST CLEAN ONLY *C/P MOVE					001 MNP GW		
	*REQD*						002 03		
							003 BL01		
<del>34C</del>	011	BAKE 4 HRS AT 350-400F					001 MNP GW		
	*REQD*	DATE IN _____ TIME IN _____					002 03		
		DATE OUT _____ TIME OUT _____					003 BK03		
		*C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
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2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN ORIFICE TUBE						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		[REDACTED] *C/P MOVE				M	001 MNPRA 002 05 003 MS03		
846	020	E & I INSPECTION SEAL LANDS O.D. 1.990/1.991 WEAR 1.987 I.D. 1.995/1.997 WEAR 1.999					001 MNPRA 002 04 003 E101		
		SPLINES AREA OVER 2 PINS 1.8847/1.8867 WEAR 1.8827 TUBE SEAL GROOVES 1.748/1.750/1.743							
8	035	POLISH ID TO CLEAN UP ONLY MAX ID 1.9990 *C/P MOVE*					001 MNPRA 002 01 003 RE01		
8	036	HONE I.D. TO CLEAN UP ONLY. MAX I.D. 1.999					001 MNPRA 002 01 003 HVO 005 X8745245		
8	038	CHECK RACEWAYS TO CENTERLINE .623/.627 *REQD*					001 MNPRA 002 02 003 GS01 005 X8745174		
26	040	VAPOR DEGREASE *C/P MOVE					001 MNPRA 002 03 003 IG01		
26	042	STRIP CHROME, SEAL LANDS OD *C/P MOVE					001 MNPRA 002 02 003 SC02		
8	044	FIRST GRIND SEAL LANDS OD MIN DIA 1.970 *C/P MOVE*					001 MNPRA 002 02 003 GE00 005 X8745763		
8	045	FIRST GRIND TUBE SEAL GROOVES O.D. NOT TO EXCEED 1.730 *C/P MOVE					001 MNPRA 002 02 003 GE02		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES				11 STOCK NUMBER		12 OPTIONAL			
13 SERIAL NUMBER				14 NOUN ORIFICE TUBE					
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. P	20. Q	
		[REDACTED]				M		001 MNP NA 002 06 003 TE03	
		TIME OUT _____ DATE OUT _____ *C/P MOVE							
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *							
26B	048	BAKE 4 HRS WITHIN 8 HRS OF ETCH DATE IN _____ TIME IN _____						001 MNP RC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		[REDACTED]				M		001 MNP NA 002 06 003 ML04	
		*C/P MOVE ***** NOTE *****							
		IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *							
26	051	VAPOR DECREASE *C/P MOVE						001 MNP RC 002 03 003 DG01	
26	052	SHOT PEEN REWORKED AREA 200% COVERAGE INTENSITY OF .006/.010 A						001 MNP RC 002 01 003 SP02	
26	053	PREPARE SEAL LANDS OD FOR CHROME PLATE CLASS 3 TYPE II MASK/FIXTURE/ ETC. MECHANIC SIGN OFF REQUIRED						001 MNP RC 002 02 003 BE01	
26	054	CHROME PLATE SEAL LANDS O.D. CLASS 3 TYPE II SUFFICIENT TO GRIND BACK TO 1.9910/1.9900 (CONTINUED)						001 MNP RC 002 02 003 CP01 008 CD010	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OR IF ICE TUBE						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		DATE OUT TIME OUT MECHANIC SIGN OFF REQUIRED *C/P MOVE							
26B ✓	055	BAKE 4 HRS. WITHIN 4 HRS. OF PLATING DATE IN TIME IN *C/P MOVE					001 MNPRC 002 02 003 BK01		
		DATE OUT TIME OUT *C/P MOVE							
8 ✓	056	FINISH GRIND SEAL LANDS OD 1.990/1.991 16RMS *C/P MOVE					001 MNPRC 002 02 003 GE00 004 X8745763		
26B ✓	058	BAKE 4 HRS. 350/400F DATE IN TIME IN *C/P MOVE					001 MNPRC 002 02 003 BK01		
		DATE OUT TIME OUT *C/P MOVE							
26 ✓	059	PREPARE TUBE SEAL GROOVES O.D. FOR NICKLE PLATE MASK/FIXTURE/ETC. *C/P MOVE					001 MNPRC 002 02 003 BE01		
26 ✓	060	PREPARE FOR NICKLE PLATE GRIT BLAST *C/P MOVE					001 MNPRC 002 02 003 SC02		
26 ✓	061	PREPARE FOR NICKLE PLATE, DEGREASE/ HAND CLEAN *C/P MOVE					001 MNPRC 002 03 003 DG01		
26 ✓	062	NICKLE PLATE TUBE SEAL GROOVES O.D. SUFFICIENT TO GRIND TO 1.748/1.750					001 MNPRC 002 03 003 NP02		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OP IF ICE TUBE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26 ✓	063	BAKE 23 HRS AT 350-400F WITHIN 4 HRS OF NICKLE PLATE DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNPRB 002 02 003 GS01 005 X8745174		
8 ✓	064	FINISH GRIND TUBE SEAL GROOVES O.D. 1.748/1.750 32RMS					001 MNPRB 002 02 003 GE02		
26 ✓	065	BAKE 4 HRS 350-400F DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNPRB 002 02 003 BK01		
26 ✓	067	STRIP CHROME RACEWAYS *C/P MOVE					001 MNPRB 002 02 003 SC02		
8 ✓	069	CHECK CENTERLINE TO RACEWAY *C/P MOVE					001 MNPRB 002 02 003 GS01 005 X8745174		
8 ✓	070	1ST GRIND 4 DEG ANGLE ON ENDS OF RACEWAYS *C/P MOVE					001 MNPRB 002 02 003 GJ02		
8 ✓	080	FIRST GRIND RACEWAYS MIN .6000, FROM CENTER LINE *C/P MOVE					001 MNPRB 002 02 003 GS01 005 X8745174		
<p>*****NOTE*****</p> <p>IF RACEWAY ARE GROUND INITIATE OP. 090,100,110,120,140,151,153,154, (CONTINUED)</p>									
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN ORIFICE TUBE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		200, 205 & 210							
		TIME OUT _____ DATE OUT _____ *C/P MOVE				M		001 MNFNA 002 06 003 TE03	
		***** NOTE ***** IF LAST NDJ OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *							
16B	100	BAKE 4 HRS WITHIN 8 HRS OF ETCH DATE IN _____ TIME IN _____						001 MNFRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		***** NOTE ***** IF LAST NDJ OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *				M		001 MNFNA 002 06 003 ML04	
26	115	VAPOR DEGREASE *C/P MOVE						001 MNFRC 002 03 003 DG01	
26	120	***** NOTE ***** DO NOT SHOTPEEN RACEWAYS IF THEY * ARE TO BE FLASH CHROMED. *						001 MNFRC 002 01 003 SP02	
		SHOT PEEN REWORKED AREAS ONLY 200% COVERAGE AT .006/.010A INTENSITY (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN ORIFICE TUBE						
15. DISPATCH STATION	16 PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		PC/P MOVE							
26 ✓	125	CLASS BEAD THREADS .004/.008A INTENSITY PC/P MOVE					001 MNPRC 002 01 003 BLOC		
26 ✓	130	PREPARE RACEWAYS FOR FLASH CHROME CLASS 3 TYPE I .0003 MIN. MASK/ FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED					001 MNPRC 002 02 003 BE01		
26 ✓	135	FLASH CHROME RACEWAYS CLASS 3 TYPE I .0003 MIN DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED PC/P MOVE					001 MNPRC 002 02 003 CP01 008 C0020		
26 ✓	138	PREPARE RACEWAYS FOR CHROME PLATE CLASS 3 TYPE II. MASK/FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED					001 MNPRC 002 02 003 BE01		
26 ✓	140	CHROME PLATE RACEWAYS CLASS 3 TYPE II DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED *C/P MOVE					001 MNPRC 002 02 003 CP01 006 C0020		
268 ✓	145	BAKE 4 HRS. WITHIN 4 HRS. OF PLATING DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN ORIFICE TUBE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
8 ✓	150	FINISH GRIND 4 DEG ANGLE ON ENDS OF RACEWAYS  *C/P MOVE					001 MNPRB 002 02 003 GJ02		
8 ✓	153	FINISH GRIND RACEWAYS SUFFICIENT TO CLEAN-UP 16RMS. 90% IAW T.O. PAGE 5-2 PARA 5-3 2-E *C/P MOVE					001 MNPRB 002 02 003 GS01 005 X8745174		
26B ✓	154	BAKE 4 HRS. 350/400F  DATE IN----- TIME IN-----  DATE OUT----- TIME OUT----- *C/P MOVE*					001 MNPRC 002 02 003 BK01		
26 ✓	155	PREPARE RACEWAYS FOR CHROME LAMINATING, MASK/FIXTURE/ETC.					001 MNPRC 002 02 003 BE01		
26 ✓	156	LAMINATE RACEWAYS SUFFICIENT TO GRIND TO .623/.627 TIME OUT----- DATE OUT----- *C/P MOVE*					001 MNPRC 002 02 003 CP01 008 C0030		
26B ✓	160	BAKE 4 HRS. WITHIN 4 HRS. OF CHROME PLATE (IF VAC CAD PLATED)  DATE IN----- TIME IN-----  DATE OUT----- TIME OUT----- *C/P MOVE					001 MNPRC 002 02 003 BK01		
8 ✓	162	FINISH GRIND RACEWAYS .623/.627 FROM CENTER LINE MUST MEET 16 RMS FINISH 90% IAW T.O. PAGE 5-2 PARA. 5-3 2-E *C/P MOVE					001 MNPRB 002 02 003 GS01 005 X8745174		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO.		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN ORIFICE TUBE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26B	104	BAKE 4 HRS AT 350/400F DATE IN_____TIME IN_____					001 MNPRC	002 02	
		DATE OUT_____TIME OUT_____+C/P MOVE					003 BK01		
26	180	PREPARE SPLINES FOR FLASH CHROME PLATE CLASS 3 TYPE II. MASK/FIXTURE/ ETC. MECHANIC SIGN OFF REQUIRED					001 MNPRC	002 02	
							003 BE01		
26	192	FLASH CHROME PLATE SPLINES CLASS 3 TYPE II DATE OUT_____TIME OUT_____					001 MNPRC	002 02	
		MECHANIC SIGN OFF REQUIRED					003 CP01	008 CD040	
		+C/P MOVE							
26B	193	BAKE 4 HRS. WITHIN 4 HRS. OF PLATING DATE IN- ----- TIME IN- -----					001 MNPRC	002 02	
		DATE OUT----- TIME OUT-----					003 BK01		
		+C/P MOVE*							
		*C/P MOVE*				M	001 MNPRC	002 06	
		***** NOTE *****					003 ML04		
		IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT.							
		*****							
26	205	VAPOR DEGREASE					001 MNPRC	002 03	
		+C/P MOVE					003 DG01		
		*C/P MOVE				M	001 MNPRC	002 06	
		***** NOTE *****					003 ZS01		
(CONTINUED)									
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36504N			
		B		D					

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2 JOB ORDER NO		3. QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN ORIFICE TUBE						
15. DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		REQUIRES 23 HRS. BAKE IF PART IS TO BE VACUUM CAD- PLATED AND HAS NOT RECEIVED A 23 HR. BAKE AFTER THE LAST CHROME PLATE OPERATION.							
		***** N O T E ***** IF LAST NOT OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. + *****							
26B ✓	213	BAKE 23 HRS AT 350-400 F IF PART IS TO BE VAC CAD OR VAC IVD PLATED. DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
26 ✓	217	PRIOR TO CAD/VAC CAD/IVD, GRIT BLAS ALL AREAS TO BE CAD/VAC CAD/IVD PLATED. *C/P MOVE					001 MNPRC 002 01 003 BL04		
26 ✓	220	VACUUM CAD PLATE TYPE II CLASS 2 *C/P MOVE					001 MNPRC 002 02 003 VC01		
26 ✓	230	CAD PLATE TYPE II CLASS 2 .40 SQ FT AT 60 AMPS PER SQ FT TIME OUT _____ DATE OUT _____ *C/P MOVE					001 MNPRC 002 03 003 CA01		
26B ✓	240	BAKE 23 HRS WITH 14 HRS OF CAD DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
26 ✓	243	IRIDITE *C/P MOVE					001 MNPRC 002 02 003 IR01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36504N			
		B		D					

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2 JOB ORDER NO		3. QUANTITY		4 PRODUCTION SEC/RCC		5. DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES				11 STOCK NUMBER		12 OPTIONAL			
13 SERIAL NUMBER				14 NOUN OP IF ICE TUBE					
15 DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
	✓ 165	*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. + + + + +				M	001 MNPRC 002 06 003 ML04		
26 ✓	247	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 213 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION. *C/P MOVE					001 MNPRC 002 03 003 1V01		
26 ✓	248	ALDINE IVD ALUM PLATE CLASS 1A *C/P MOVE					001 MNPRC 002 03 003 TA01		
8 ✓	249	CHECK I.D. FOR CORROSION, HONE I.D. IF CORRODED. MAX I.D. 1.999 *REQD* CLEAN & PROTECT I.D. WITH MIL-C-16173D, GRADE 1 CORROSION PREVENTIVE COMPOUND * C/P MOVE					001 MNPRC 002 01 003 HV02 005 X8745244		
	250	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958					001 MNPRC 002 06 003 SA03		
	260	FINAL PRODUCT VISUAL INSPECTION *REQD* *C/P MOVE					001 MNPRC 002 06 003 SA03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36504N			
		B		D					



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2 JOB ORDER NO 17402A		3 QUANTITY		4 PRODUCTION SEC/RCC MNPGR		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER 68A450610-2003				8. TECH DATA 4S-1-182 4S2-73-3				9. ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES 1-15 NOSE			11 STOCK NUMBER 1620003109834			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN CRANK STEERING			<b>17402A</b>			
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 BLAST IAW MIL-STD-1504 FPI IAW MIL-STD-6866							
		BAKE IAW 4S-1-182 MAOI 74-12 CHROME PLATE IAW MIL-STD-1501 P/O N61891							
		CAD PLATE IAW MIL-STD-870 FMP1 IAW MIL-STD-1949 P/O N01561 VAC 1VD ALUM PLATE IAW MIL-C-80468A							
		ALUMINE IAW MIL-C-5541 TEMPER ETC IAW MIL-STD-867 ***UNIT COST \$781.10*** ***STEEL 300M 280-300 KSI***							
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FROM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/EN			
DISPATCH	FUNCTIONAL CODE	A				C			
		B				D			
						36506N			

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIAL			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN CRANK STEERING						
15. DISPATCH STATION	16 PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19 P	20. Q	
		EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELIA STAMP.							
	001	68A450610-2000							
	005	DISASSEMBLE *C/P MOVE						001 MNP GW 002 02 003 L002 005 X8745199	
	007	CHEM CLEAN *C/P MOVE						001 MNP GW 002 03 003 SL01	
34B	009	BLAST CLEAN ONLY *C/P MOVE						001 MNP GW 002 03 003 BL07	
34B	011	BAKE 4 HRS AT 350-400F						001 MNP GW 002 03 003 BK03	
		DATE IN _____ TIME IN _____							
		DATE OUT _____ TIME OUT _____							
		*C/P MOVE							
		[REDACTED] *C/P MOVE				M		001 MNP NA 002 05 003 MS03	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36506N			
		B		D					

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES				11 STOCK NUMBER		12 OPTIONAL			
13 SERIAL NUMBER				14 NOUN CRANK STEERING					
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
34E	025	E & I INSPECT					001 MNP GW		
	*REQD*	MEASURE ID OF SPLINES USING .120 PINS 1.5033/1.5068					002 04		
		ACTUATOR BOSS OD .748/.749/.746 *C/P MOVE					003 EI01		
26	027	VAPOR DEGREASE				*C/P MOVE	001 MNP RC		
							002 03		
							003 IG01		
26	028	STRIP LAD				*L/P MOVE	001 MNP RC		
							002 02		
							003 CS01		
26	029	STRIP RUST				*C/P MOVE	001 MNP RL		
							002 02		
							003 CS02		
26	031	STRIP CHROME ACTUATOR BOSS U.D. ONLY				C/P MOVE	001 MNP RL		
							002 02		
							003 SC02		
26	032	STRIP FLASH CHROME FROM SPLINE I.D.				C/P MOVE	001 MNP RL		
							002 02		
							003 SC02		
36	035	RECENTER CRANK					001 MNP RA		
		*C/P MOVE					002 03		
							003 LE02		
8	040	1ST GRIND BOSS OD MIN .734 32RMS					001 MNP RB		
		*C/P MOVE					002 02		
							003 GJ02		
DATE OUT _____ TIME OUT _____ (CONTINUED)						M	001 MNP RA		
							002 06		
							003 TE03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36506N			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN CRANK STEERING						
15 DISPATCH STATION	16 PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*C/P MOVE *****NOTE***** IF LAST ND1 OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *							
		*****							
25R	060	BAKE 4 HRS AT 350-400F WITHIN 8 HRS OF ETCH DATE IN _____ TIME IN _____						001 MNPRL 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		[REDACTED] *C/P MOVE *****NOTE***** IF LAST ND1 OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *				M		001 MNPNA 002 06 003 ML04	
		*****							
26	075	VAPOR DEGREASE *C/P MOVE						001 MNPRL 002 03 003 DG01	
26	080	SHOT PEEN REWORK AREA 200% COVERAGE INTENSITY OF .003/.006A C/P MOVE						001 MNPRL 002 01 003 SP02	
26	082	GLASS BEAD BLAST THREADS INTENSITY OF .004/.008A						001 MNPRL 002 01 003 BL03	
26	083	PREPARE SPLINES ID FOR CHROME PLATE GRIT BLAST. *C/P MOVE						001 MNPRL 002 01 003 BL04	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		36506N			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN CRANK STEERING						
15. DISPATCH STATION	16. PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26 C	084	PREPARE SPLINES ID FOR CHROME PLATE MASK/FIXTURE/ETC.					001 MNP RC	002 02 003 BE01	
26 E	085	FLASH CHROME PLATE SPLINES I.D. C/P MOVE					001 MNP RC	002 02 003 CP01 008 CI010	
26 E	086	BAKE 4 HRS AT 350-400 F WITHIN 4 HRS OF CHROME. DATE IN _____ TIME IN _____					001 MNP RC	002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
26 E	088	PREPARE BOSS OD FOR CHROME PLATE TYPE II CLASS 3. MASK/FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED					001 MNP RC	002 02 003 BE01	
26 E	089	PREPARE BOSS OD FOR CHROME PLATE, GRIT BLAST. *C/P MOVE					001 MNP RC	002 01 003 BL04	
26 E	090	CHROME PLATE BOSS O.D. TYPE II CLASS III SUFFICIENT TO GRIND TO .748/.749					001 MNP RC	002 02 003 CP01 008 CD010	
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED *C/P MOVE							
26B E	100	BAKE 4 HRS AT 350-400F WITHIN 4 HRS OF CHROME DATE IN _____ TIME IN _____					001 MNP RC	002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36506N			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN CRANK STEERING						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
8	110	FINISH GRIND BOSS DD .748/.749 *C/P MOVE					001 MNP RC 002 02 003 GJ02		
105	120	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNP RC 002 02 003 BK01		
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *				M	001 MNP NA 002 06 003 ML04		
26	130	VAPOR DEGREASE *C/P MOVE					001 MNP RC 002 03 003 DG01		
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *				M	001 MNP NA 002 06 003 ZS01		
26	145	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED. *C/P MOVE					001 MNP RC 002 01 003 BL02		
26	150	CAD PLATE TYPE II CLASS II .01 SQ FT AT 5 - 7 AMPS TIME OUT _____ DATE OUT _____ (CONTINUED)					001 MNP RC 002 03 003 CA01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36506N			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN CRANK STEERING						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18 MECHANIC	19. "P"	20. "Q"	
		*C/P MOVE							
268 (	155	BAKE 23 HRS AT 350-400F WITHIN 4 HRS OF CAD DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
26 (	160	CHROMATE CONVERSION FOR TYPE [1] CAD *C/P MOVE					001 MNPRC 002 02 003 IR01		
	.65	[REDACTED] *C/P MOVE * * * * * NOTE * * * * * IF LAST NOJ OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. * * * * *				M	001 MNINA 002 06 003 RL04		
26 (	184	IVD PLATE (INITIATED BY PLATING) *NOTE* OPERATION 155 MUST BE ACCOMPLISHED PRIOR TO USING IVD OPTION. C/P MOVE					001 MNPRC 002 03 003 IV01		
26 (	188	ALODINE IVD AREAS (INITIATED BY PLATING) C/P MOVE					001 MNPRC 002 03 003 TA01		
34A	[REDACTED] *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					001 MNPRC 002 06 003 SA03		
34A	[REDACTED] *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					001 MNPRC 002 06 003 SA03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36506N			
		B		D					

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2 JOB ORDER NO 17402A	3 QUANTITY	4 PRODUCTION SEC/RCC NNPGP	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER 68A450625-2001	8. TECH DATA 4S-1-182 4S2-73-3		9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES F-15 NOSE	11 STOCK NUMBER 5306003291614	12 OPTIONAL		
13 SERIAL NUMBER	14 NOUN UPPER STEERING BOLT	17402A		

15. DISPATCH STATION	16. PERF RCC/CP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*****UNIT COST: \$29.89***** GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 FMPI IAW MIL-STD-1949			
		FPI IAW MIL-STD-6866 CHROME STRIP IAW MIL-STD-871 GRIND IAW MIL-STD-866 TEMPER ETCH IAW MIL-STD-867			
		SHOT PEEN IAW MIL-S-13165 CHROME PLATE IAW MIL-STD-1501 VAC CAD IAW MIL-C-8837 CAD IAW MIL-STD-870			
		BAKE IAW 4S-1-182 MAOI 74-12 VAC IVD ALUM PLATE IAW MIL-C-83488A /LODINE IAW MIL-C-5541			
		BLAST IAW MIL-STD-1504  STEEL 180,000/200,000			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. *****WARNING***** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36513N
		B	D	



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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO.		
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN UPPER STEERING BOLT						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 "Q"	
		PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN							
		BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP							
	001	68A450625-2001							
	005 *REQD*	DISASSEMBLE *C/P MOVE						001 MNP GW 002 02 003 L002 005 X8745199	
	007 *REQD*	CHEM CLEAN *C/P MOVE						001 MNP GW 002 03 003 SL01	
	009 *REQD*	BLAST CLEAN ONLY *C/P MOVE						001 MNP GW 002 03 003 RL07	
	011 *REQD*	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE						001 MNP GW 002 03 003 BK03	
		[REDACTED] *C/P MOVE *REQD*				M		001 MNP NA 002 05 003 MS03	
	040 *REQD*	E & I BOLT O.D. .99817/.999 WEAR LIMIT .996 *C/P MOVE						001 MNP GW 002 04 003 EI01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36513N			
		B		D					

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN UPPER STEERING BOLT						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
26 C	044	VAPOR DECREASE *C/P MOVE						001 MNPRC 002 03 003 DG01	
26 :	046	STRIP CAD *C/P MOVE						001 MNPRC 002 02 003 CS01	
26 :	048	STRIP RUST *C/P MOVE						001 MNPRC 002 02 003 CS02	
26 :	050	STRIP CHROME BOLT O.D. *C/P MOVE						001 MNPRC 002 02 003 SC02	
69 /	060	RECENTER *C/P MOVE						001 MNPRC 002 03 003 LE02	
8 /	070	FIRST GRIND BOLT O.D. TO CLEAN UP NOT TO EXCEED .978 MIN *C/P MOVE						001 MNPRC 002 01 003 GE00	
		DATE OUT _____ TIME OUT _____				M		001 MNPRC 002 06 003 TE03	
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *							
		*****							
26B E	090	BAKE 4 HRS AT 350-400F WITHIN 8 HRS OF ETCH						001 MNPRC 002 02 003 BK01	
(CONTINUED)									
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36513N			
		B		D					

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL/DESIGN/SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN UPPER STEERING BOLT						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18 MECHANIC	19. "P"	20. "Q"	
		DATE IN _____ TIME IN _____							
		DATE OUT _____ TIME OUT _____							
		*C/P MOVE							
		*C/P MOVE				M	001 MNPNA		
		***** N O T E *****					002 06		
		IF LAST NOJ OPERATION IS COMPLETED					003 ML04		
		HERE, TAKE PRODUCTION COUNT. *							
		*****							
26	105	VAPOR DECREASE *C/P MOVE					001 MNPRC		
							002 03		
							003 IG01		
26	110	SHOT BEEN REWORKED AREA INTENSITY OF .006/.010A *C/P MOVE					001 MNPRC		
							002 01		
							003 SP02		
26	115	PREPARE FOR CHROME PLATE BOLT O.D. TYPE II CLASS III MASK/FIXTURE/ETC					001 MNPRC		
		MECHANIC SIGN OFF REQUIRED					002 02		
		*C/P MOVE					003 BE01		
26	120	CHROME PLATE BOLT O.D. TYPE II CLASS III SUFF. TO GRIND BACK TO .9981/.999					001 MNPRC		
							002 02		
							003 CP01		
							008 CD010		
		TIME OUT _____ DATE OUT _____							
		MECHANIC SIGNOFF *RECD* _____							
		*C/P MOVE							
26B	130	BAKE 4 HRS WITHIN 4 HRS OF CHROME PLATE					001 MNPRC		
							002 02		
							003 BK01		

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	36513N
		B	D	

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## 36513N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89039

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7. PART NUMBER				8 TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN UPPER STEERING BOLT						
15 DISPATCH STATION	16. PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19. "P"	20. "Q"	
		DATE IN _____ TIME IN _____							
		DATE OUT _____ TIME OUT _____							
		*C/P MOVE							
B ✓	140	FINISH GRIND BOLT O.D. .9981/.999 63 RMS *C/P MOVE						001 MNPRB 002 01 003 CE00	
DSB	150	BAKE 4HRS AT 350-400F						001 MNPRC 002 02 003 BK01	
		DATE IN _____ TIME IN _____							
		DATE OUT _____ TIME OUT _____							
		*C/P MOVE							
		[REDACTED] *C/P MOVE							
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *				M		001 MNPRNA 002 06 003 PL04	
		*****							
26 S	157	VAPOR DEGREASE *C/P MOVE						001 MNPRC 002 03 003 DC01	
		[REDACTED] *C/P MOVE							
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *				M		001 MNPRNA 002 06 003 ZS01	
		*****							
26 S	165	PRIOR TO VAC CAD/CAD/IVD, GRIT BLAST ALL AREAS TO BE VAC CAD/CAD/ IVD PLATED. *C/P MOVE						001 MNPRC 002 01 003 BL04	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36513N			
		B		D					

\* U.S. GOVERNMENT PRINTING OFFICE: 1988-548-103

2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETE	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN UPPER STEERING BOLT						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26	170	VAC CAD PLATE TYPE II CLASS II *C/P MOVE					001 MNPRC 002 02 003 VC01		
26	180	CAD PLATE TYPE II CLASS II  TIME OUT _____ DATE OUT _____ *C/P MOVE					001 MNPRC 002 03 003 CA01		
26B	190	BAKE 23 HRS WITHIN 4HRS OF CAD PLATE  DATE IN _____ TIME IN _____  DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
26	200	IRIDITE *C/P MOVE					001 MNPRC 002 02 003 IR01		
	165	[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *****				M	001 MNPRC 002 06 003 ML04		
26	214	IVD PLATE (INITIATED BY PLATING) *NOTE* OPERATION 190 MUST BE ACCOMPLISHED PRIOR TO USING IVD OPTION C/P MOVE					001 MNPRC 002 03 003 IV01		
26	218	ALODINE IVD AREAS (INITIATED BY PLATING) C/P MOVE					001 MNPRC 002 03 003 TA01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		36513N			
		B		D					

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PREVIOUS EDITION WILL BE USED

F-15 NL6

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 09/21/82 A-20462-MN1-DY-M45 PAGE 000  
 17402A STRUT F-15 NOSE RCC MNRA 462-73-3

SUP	T K	W F PF A/R REV	NR A FA SUPPORT	CCC	DESCRIPTION	BASE	PRD	STD	
STEP	D L	K C DC ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT
BASE01	S E	JA EA 1	K 82162	1.00	PERCENT ENGR 94.4	F-15 OUTER CYL	6.76	6.76	
0001		JA 01	00	.00	PART NUMBER/NSN	.000	.000	.000	0
					66A450602-1001 1520003109830				
0045		JA 01	15	.23	REMOVE BUSHING/1" DIA	.203	.007	.054	1
0010 E			RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL PRORATE OVER 4 PARTS	.27525		.079	
0020 E			RLG-RS-KA	16.00	K/O SINGLE BUSH 1/4-1 IN DIA REMOVE BUSHING WITH KNOCKER	.00780		.143	
0030 E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0048		JA 01	15	.08	O/S HOLE ON MILL/MED PART	.776	.009	.071	1
0010 E			RNL-SU-V2	.25	S/U VERT MILL BORE LRG FIXTRPRORATE OVER 4 PARTS	.80167		.230	
0020 E			RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP	.15776		.181	
0030 E			RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699		.146	
0040 E			RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609		.087	
0050 E			RML-SA-CC	1.00	BORE HOLE 2 X 1 1/2 GROUP 1 USE PROPER ELEMENT/TABLE	.20567		.236	
0060 E			RJP-FW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0050		JA 01	15	.08	O/S HOLE ON MILL/MED PART	.776	.009	.071	1
0010 E			RNL-SU-V2	.25	S/U VERT MILL BORE LRG FIXTRPRORATE OVER 4 PARTS	.80167		.230	
0020 E			RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP	.15776		.181	
0030 E			RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699		.146	
0040 E			RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609		.087	
0050 E			RML-SA-CC	1.00	BORE HOLE 2 X 1 1/2 GROUP 1 USE PROPER ELEMENT/TABLE	.20567		.236	
0060 E			RJP-FW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
		JA 01	15	.05	OVERSIZE HOLE WITH REAMER	.275	.002	.016	0
0010 E			RBW-SU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E			RLG-HP-V7	1.00	OBJ IN/OUT STP VISE-HST HAND	.06831		.078	
0030 E			RBW-BU-R2	2.00	REAM WITH LEMPCO REAMER 3 PASSES	.07337		.168	
0040 E			RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423		.004	
0050 E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0052		JA 01	15	.05	OVERSIZE HOLE WITH REAMER	.275	.002	.016	0
0010 E			RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E			RLG-HP-V7	1.00	OBJ IN/OUT STP VISE-HST HAND	.06831		.078	
0030 E			RBW-BU-R2	2.00	REAM WITH LEMPCO REAMER 3 PASSES	.07337		.168	
0040 E			RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423		.004	
0050 E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0053		JA 01	15	.05	OVERSIZE HOLE WITH REAMER	.349	.003	.020	0
0010 E			RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E			RLG-HP-V7	1.00	OBJ IN/OUT STP VISE-HST HAND	.06831		.078	
0030 E			RBW-BU-R2	3.00	REAM WITH LEMPCO REAMER 3 PASSES	.07337		.253	
0040 E			RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423		.004	
0050 E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0054		JA 01	15	1.00	HAND HOME BUSHING	.198	.030	.228	3
0010 E			RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL PRORATE FOUR PARTS	.27525		.079	
0020 N				1.00	HONE PART NAME	.10000		.115	
0030 E			RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT	.01603		.018	
0040 E			RBW-BU-P1	1.00	BUTTERFLY POLISH BUSHING I D	.00333		.003	
0050 E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0055		JA 01	15	1.00	HAND HOME BUSHING	.198	.030	.228	3
0010 E			RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL PRORATE FOUR PARTS	.27525		.079	
0020 N				1.00	HONE PART NAME	.10000		.115	
0030 E			RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT	.01603		.018	

0040 E		RBM-BU-P1	1.00 BUTTERFLY POLISH BUSHING I D	.00333		.003	
0050 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
	JA 01	15	.08 O/S HOLE ON MILL/MED PART	.756	.009	.070	1
0010 E		RML-SU-V2	.25 S/U VERT MILL BORE LRG FIXTRPRORATE OVER 4 PARTS	.80167		.230	
0020 E		RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP	.15776		.181	
0030 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD	.12699		.146	
0040 E		RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD	.07609		.087	
0050 E		RML-BA-AB	1.00 BORE HOLE 1 X 1 GROUP 1	.18482		.212	
0060 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0057	JA 01	15	.05 HAND HONE BUSHING	.278	.002	.016	0
0010 E		RBM-SU-S1	.25 S/U FOR BENCH WORK GENERAL PRORATE FOUR PARTS	.27525		.077	
0020 N			2.00 HONE PART NAME	.10000		.230	
0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0053	JA 01	15	.05 O/S HOLE ON MILL/MED PART	.733	.006	.045	1
0010 E		RML-SU-V2	.25 S/U VERT MILL BORE LRG FIXTRPRORATE OVER 4 PARTS	.80167		.230	
0020 E		RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP	.15776		.181	
0030 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD	.12699		.146	
0040 E		RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD	.07609		.087	
0050 E		RML-BA-AG	1.00 BORE HOLE 1 X 3 1/2 GROUP 1 USE PROPER ELEMENT/TABLE	.21212		.243	
0060 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0124	JA 01	15	.05 TURN BUSHING GROUP 1/BRONZE	.211	.002	.012	0
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK	.01006		.011	
0030 E		KML-TA-CC	1.00 DIA .501-1.00 REM .033-.250	.06699		.077	
0040 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0135	JA 01	15	.05 INST STRAIGHT BUSH NO POLISH	.077	.001	.004	0
0010 E		RBM-BU-S1	.25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBM-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING	.23062		.023	
0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
	JA 01	15	.88 TURN BUSHING GROUP 1/BRONZE	.289	.038	.292	4
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK	.01006		.023	
0030 E		KML-TA-CC	2.00 DIA .501-1.00 REM .033-.250	.06699		.154	
0040 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0190	JA 01	15	.88 INST/REAM SET FLANGED BUSH	.295	.039	.299	4
0010 E		RBM-BU-S1	.25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBM-BU-S1	1.00 REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.274	
0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0194	JA 01	15	.05 TURN BUSHING GROUP 1/BRONZE	.289	.002	.017	0
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK	.01006		.023	
0030 E		KML-TA-CC	2.00 DIA .501-1.00 REM .033-.250	.06699		.154	
0040 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0195	JA 01	15	.05 INST/REAM SET FLANGED BUSH	.295	.002	.017	0
0010 E		RBM-BU-S1	.25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBM-BU-S1	1.00 REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.274	
0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0199	JA 01	15	.83 TURN BUSHING GROUP 1/BRONZE	.239	.036	.276	4
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK	.01006		.023	
0030 E		KML-TA-CC	2.00 DIA .501-1.00 REM .033-.250	.06699		.154	
0040 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0200	JA 01	15	.83 INST/REAM SET FLANGED BUSH	.295	.037	.282	4
0010 E		RBM-BU-S1	.25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBM-BU-S1	1.00 REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.274	
0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	



0204	JA 01	15	.05	TURN BUSHING GROUP 1/BRONZE	.289	.002	.017	0
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK		.01006		.023	
0030 E		KML-TA-CC	2.00 DIA .501-1.00 REM .033-.250		.06699		.154	
0040 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0205	JA 01	15	.05	INST/REAM SET FLANGED BUSH	.295	.002	.017	0
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	1.00 REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0219	JA 01	15	.38	TURN BUSHING GROUP 1/BRONZE	.289	.038	.292	4
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK		.01006		.023	
0030 E		KML-TA-CC	2.00 DIA .501-1.00 REM .033-.250		.06699		.154	
0040 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0220	JA 01	15	.88	INST/REAM SET FLANGED BUSH	.295	.039	.299	4
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	1.00 REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0224	JA 01	15	.05	TURN BUSHING GROUP 1/BRONZE	.289	.002	.017	0
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK		.01006		.023	
0030 E		KML-TA-CC	2.00 DIA .501-1.00 REM .033-.250		.06699		.154	
0040 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0225	JA 01	15	1.00	INST/REAM SET FLANGED BUSH	.295	.044	.339	5
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	1.00 REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0230	JA 01	15	.05	TURN BUSHING GROUP 1/BRONZE	.289	.002	.017	0
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK		.01006		.023	
0030 E		KML-TA-CC	2.00 DIA .501-1.00 REM .033-.250		.06699		.154	
0040 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0233	JA 01	15	.88	INST/REAM SET FLANGED BUSH	.295	.039	.299	4
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	1.00 REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0234	JA 01	15	.05	TURN BUSHING GROUP 1/BRONZE	.289	.002	.017	0
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK		.01006		.023	
0030 E		KML-TA-CC	2.00 DIA .501-1.00 REM .033-.250		.06699		.154	
0040 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0235	JA 01	15	.05	INST/REAM SET FLANGED BUSH	.295	.002	.017	0
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	1.00 REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0239	JA 01	15	1.00	TURN BUSHING GROUP 1/BRONZE	.366	.055	.421	6
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	3.00 1ST PART IN-OUT SCROLL CHUCK		.01006		.034	
0030 E		KML-TA-CC	3.00 DIA .501-1.00 REM .033-.250		.06699		.231	
0040 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0240	JA 01	15	1.00	INST/REAM SET FLANGED BUSH	.295	.044	.339	5
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	1.00 REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0010 E	JA 01	15	.05	TURN BUSHING GROUP 1/BRONZE	.366	.003	.021	0
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	

0020 E	SLA-HP-C1	3.00	1ST PART IN-OUT SCROLL CHUCK	.01006	.024	
0030 E	KML-TA-CC	3.00	DIA .501-1.00 REM .033-.250	.06699	.231	
40 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
JA 01 15		.05	INST/REAM SET FLANGED BUSH	.295	.002	.017 0
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669	.053	
0020 E	RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835	.274	
0030 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0249 JA 01 15		1.00	TURN BUSHING GROUP 4/STEEL	.411	.062	.473 7
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962	.143	
0020 E	RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	.01006	.023	
0030 E	KML-TD-CC	2.00	DIA .501-1.00 REM .033-.250	.10898	.250	
0040 E	KML-TD-CD	1.00	DIA 1.00 REM .250 ADD INCH	.03865	.044	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0250 JA 01 15		1.00	INST STRAIGHT BUSH NO POLISH	.763	.114	.678 13
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669	.053	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0030 E	RBW-SU-G1	2.00	S/U FOR BENCH WORK GENERAL PRORATE FOUR PARTS	.27525	.633	
0040 N		1.00	HONE PART NAME	.10000	.115	
0060 E	RSG-JP-05	2.00	PREP HAND DRILL CHANGE 1 BIT	.01603	.036	
0070 E	RBW-BU-P1	1.00	BUTTERFLY POLISH BUSHING I D	.00333	.003	
0080 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0254 JA 01 15		.05	TURN BUSHING GROUP 4/STEEL	.411	.063	.024 0
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962	.143	
0020 E	RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	.01006	.023	
0030 E	KML-TD-CC	2.00	DIA .501-1.00 REM .033-.250	.10898	.250	
0040 E	KML-TD-CD	1.00	DIA 1.00 REM .250 ADD INCH	.03865	.044	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
JA 01 15		.05	INST STRAIGHT BUSH NO POLISH	.763	.006	.044 1
010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669	.053	
020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0030 E	RBW-SU-G1	2.00	S/U FOR BENCH WORK GENERAL PRORATE FOUR PARTS	.27525	.633	
0040 N		1.00	HONE PART NAME	.10000	.115	
0060 E	RSG-JP-05	2.00	PREP HAND DRILL CHANGE 1 BIT	.01603	.036	
0070 E	RBW-BU-P1	1.00	BUTTERFLY POLISH BUSHING I D	.00333	.003	
0080 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0259 JA 01 15		.96	TURN BUSHING GROUP 1/BRONZE	.289	.042	.319 5
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962	.143	
0020 E	RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	.01006	.023	
0030 E	KML-TA-CC	2.00	DIA .501-1.00 REM .033-.250	.06699	.154	
0040 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0260 JA 01 15		.96	INST/REAM SET FLANGED BUSH	.295	.042	.326 2
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669	.053	
0020 E	RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835	.274	
0030 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0264 JA 01 15		.05	TURN BUSHING GROUP 1/BRONZE	.278	.002	.016 0
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962	.143	
0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK	.01006	.023	
0030 E	KML-TA-CC	2.00	DIA .501-1.00 REM .033-.250	.06699	.154	
0040 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0265 JA 01 15		.05	INST/REAM SET FLANGED BUSH	.295	.002	.017 0
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669	.053	
0020 E	RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835	.274	
0030 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
JA 01 15		.05	TURN BUSHING GROUP 1/BRONZE	.211	.002	.012 0
010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962	.143	
0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK	.01006	.023	

0030 E	KML-TA-EC	1.00 DIA 1.50-2.00 REM .033-.250	.06699	.077	
0040 E	RJP-PW-R1	1.00 REM RPL PAPERWK SIGN OFF DOC	.01001	.011	
	JA 01 15	.05 INST STRAIGHT BUSH NO POLISH	.265	.002	0
010 E	RBW-BU-S1	.25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669	.053	
0020 E	RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0030 E	RBW-SU-G1	.25 S/U FOR BENCH WORK GENERAL PRORATE FOUR PARTS	.27525	.079	
0040 N		1.00 HONE PART NAME	.10000	.115	
0060 E	RSG-JP-05	1.00 PREP HAND DRILL CHANGE 1 BIT	.01603	.018	
0070 E	RBW-BU-P1	1.00 BUTTERFLY POLISH BUSHING I D	.00333	.003	
0050 E	RJP-PW-R1	1.00 REM RPL PAPERWK SIGN OFF DOC	.01001	.011	
0285	JA 01 15	.92 TURN BUSHING GROUP 1/BRONZE	.239	.040	5
0010 E	RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962	.143	
0020 E	RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK	.01006	.023	
0030 E	KML-TA-EC	2.00 DIA 1.50-2.00 REM .033-.250	.06699	.154	
0040 E	RJP-PW-R1	1.00 REM RPL PAPERWK SIGN OFF DOC	.01001	.011	
0290	JA 01 15	.92 INST STRAIGHT BUSH NO POLISH	.107	.015	2
0010 E	RBW-BU-S1	.25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669	.053	
0020 E	RBW-BU-A4	2.00 INSTALL ONE STRAIGHT BUSHING	.02062	.047	
0030 E	RJP-PW-R1	2.00 REM RPL PAPERWK SIGN OFF DOC	.01001	.023	
0294	JA 01 15	.05 TURN BUSHING GROUP 1/BRONZE	.239	.002	0
0010 E	RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962	.143	
0020 E	RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK	.01006	.023	
0030 E	KML-TA-EC	2.00 DIA 1.50-2.00 REM .033-.250	.06699	.154	
0040 E	RJP-PW-R1	1.00 REM RPL PAPERWK SIGN OFF DOC	.01001	.011	
0295	JA 01 15	.05 INST STRAIGHT BUSH NO POLISH	.763	.006	1
0010 E	RBW-BU-S1	.25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669	.053	
0020 E	RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0030 E	RBW-SU-G1	2.00 S/U FOR BENCH WORK GENERAL PRORATE FOUR PARTS	.27525	.633	
040 N		1.00 HONE PART NAME	.10000	.115	
060 E	RSG-JP-05	2.00 PREP HAND DRILL CHANGE 1 BIT	.01603	.024	
0070 E	RBW-BU-P1	1.00 BUTTERFLY POLISH BUSHING I D	.00333	.003	
0060 E	RJP-PW-R1	1.00 REM RPL PAPERWK SIGN OFF DOC	.01001	.011	
0000	JA 01 00	.01 LABOR STANDARD HISTORY	.300	.300	0
0010		KIM VINCENT, MANEL, 10 JUN 68			

TO INTERROGATE LASER STANDARDS, INPUT

EOC PRD NROP NR

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1234567890123456 ELSE PUT IN END

W F FF A/R REV												A
SUB	T K	NR	A	FA	SUPPORT	DOC	DESCRIPTION	BASE	PFD	STD		
STEP	D L	K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	PLY PCT C
4502	S	E	JA	EA	1	K 88161	1.00 PERCENT ENGR 99.9	F-15 NLG SUPPORT ARM	7.22		7.22	
0001			JA	01	00		.00	PART NUMBER/NSN	.000	.000	.000	0
							68A450643-1001	1620003051726				
0010			JA	01	15		1.00	O/S BOLT HOLES	.604	.091	.695	10
0010	E				KMM-SU-V1	.25 S/U VERT MILL BORE SMAL	EXTRPRGRATE OVER 4 PARTS		.50518		.145	
0020	E				RML-HP-CA	1.00 HAND HANDLE NO WRAP 2 CLAMPS			.08531		.093	
0030	E				RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD			.12699		.146	
0040	E				RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD			.07609		.057	
0050	E				RML-BA-AA	1.00 BORE HOLE 1 X 1/2 GROUP 1	USE PROPER ELEMENT/TABLE		.17936		.206	
0060	E				RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC			.01001		.011	
0023			JA	01	15		1.00	MACH FACES	.631	.095	.726	10
0010	E				KMM-SU-V1	.25 S/U VERT MILL BORE SMAL	EXTRPRGRATE OVER 4 PARTS		.50518		.145	
0020	E				RML-HP-CA	1.00 HAND HANDLE NO WRAP 2 CLAMPS			.08531		.093	
0030	E				RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD			.12699		.146	
0040	E				RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD			.07609		.057	
0050	E				RML-BA-AA	1.00 BORE HOLE 1 X 3 GROUP 1	USE PROPER ELEMENT/TABLE		.20666		.237	
0060	E				RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC			.01001		.011	
0024			JA	01	15		1.00	O/S UPPER BOLT HOLE	.604	.091	.695	10
0010	E				KMM-SU-V1	.25 S/U VERT MILL BORE SMAL	EXTRPRGRATE OVER 4 PARTS		.50518		.145	
0020	E				RML-HP-CA	1.00 HAND HANDLE NO WRAP 2 CLAMPS			.08531		.093	
0030	E				RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD			.12699		.146	
0040	E				RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD			.07609		.057	
0050	E				RML-BA-AA	1.00 BORE HOLE 1 X 1/2 GROUP 1	USE PROPER ELEMENT/TABLE		.17936		.206	
0060	E				RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC			.01001		.011	
0029			JA	01	15		1.00	MACH BUSHING	.307	.046	.354	5
0010	E				RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRGRATE OVER 4 PARTS		.49962		.143	
0020	E				RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS			.01006		.023	
0030	E				KML-TA-CC	2.00 DIA .501-1.00 REM .033-.250			.06699		.154	
0040	E				KML-TA-CD	2.00 DIA 1.0 REMOVE .250 ADD INCH			.00947		.021	
0050	E				RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC			.01001		.011	
0030			JA	01	15		1.00	INSTALL	.295	.044	.339	5
0010	E				RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRGRATE OVER 4 PARTS		.18669		.053	
0020	E				RBW-BU-B1	1.00 REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH		.23835		.274	
0030	E				RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC			.01001		.011	
0032			JA	01	15		1.00	INSTL O/S BUSHING	.295	.044	.339	5
0010	E				RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRGRATE OVER 4 PARTS		.18669		.053	
0020	E				RBW-BU-B1	1.00 REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH		.23835		.274	
0030	E				RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC			.01001		.011	
0034			JA	01	15		1.00	MACH O/S BUSHING	.307	.046	.354	5
0010	E				RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRGRATE OVER 4 PARTS		.49962		.143	
0020	E				RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS			.01006		.023	
0030	E				KML-TA-CC	2.00 DIA .501-1.00 REM .033-.250			.06699		.154	
0040	E				KML-TA-CD	2.00 DIA 1.0 REMOVE .250 ADD INCH			.00947		.021	
0050	E				RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC			.01001		.011	
0036			JA	01	15		1.00	INSTL O/S BUSHING	.295	.044	.339	5
0010	E				RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRGRATE OVER 4 PARTS		.18669		.053	
0020	E				RBW-BU-B1	1.00 REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH		.23835		.274	
0030	E				RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC			.01001		.011	
0038			JA	01	15		1.00	MACH UPPER LIP	.240	.036	.276	4

0010 E	RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962	.143	
0020 E	RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK		.01006	.011	
0030 E	KML-TA-GC	1.00 DIA 3.00-4.00 REM .033-.250		.07800	.089	
0040 E	KML-TA-GD	1.00 DIA 4.0 REM .250 ADD INCH		.01707	.019	
0050 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0038	JA 01	15	1.00 MACH CHAMFER	.240	.036	.276 4
0010 E	RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962	.143	
0020 E	RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK		.01006	.011	
0030 E	KML-TA-GC	1.00 DIA 3.00-4.00 REM .033-.250		.07800	.089	
0040 E	KML-TA-GD	1.00 DIA 4.0 REM .250 ADD INCH		.01707	.019	
0050 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0040	JA 01	15	1.00 MACH LOWER LIP	.614	.092	.706 10
0010 E	KYM-SU-V1	.25 S/U VERT MILL BORE SMAL FTRPRORATE OVER 4 PARTS		.50518	.145	
0020 E	RML-HP-CA	1.00 HAND HANDLE NO WRAP 2 CLAMPS		.08531	.098	
0030 E	RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD		.12699	.146	
0040 E	RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD		.07609	.087	
0050 E	RML-BA-EA	1.00 BORE HOLE 3 X 1/2 GROUP 1 USE PROPER ELEMENT/TABLE		.18962	.218	
0060 E	RJP-FW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0050	JA 01	15	1.00 MACH UPPER BEARING	.240	.036	.276 4
0010 E	RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962	.143	
0020 E	RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK		.01006	.011	
0030 E	KML-TA-GC	1.00 DIA 3.00-4.00 REM .033-.250		.07800	.089	
0040 E	KML-TA-GD	1.00 DIA 4.0 REM .250 ADD INCH		.01707	.019	
0050 E	RJP-FW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0060	JA 01	15	1.00 O/S LOWER BEARING	.216	.032	.248 3
0010 E	RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962	.143	
0020 E	RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK		.01006	.011	
0030 E	KML-TA-FC	1.00 DIA 2.00-3.00 REM .033-.250		.07104	.081	
0040 E	RJP-FW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
	JA 01	15	1.00 MACH UPPER BEARING	.297	.045	.342 5
0010 E	RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962	.143	
0020 E	RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS		.01006	.023	
0030 E	KML-TA-FC	2.00 DIA 2.00-3.00 REM .033-.250		.07104	.163	
0040 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0150	JA 01	15	1.00 MACH LOWER BEARING	.211	.032	.244 3
0010 E	RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962	.143	
0020 E	RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK		.01006	.011	
0030 E	KML-TA-EC	1.00 DIA 1.50-2.00 REM .033-.250		.06699	.077	
0040 E	RJP-FW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0160	JA 01	15	1.00 MACH UPPER LIP	.229	.034	.264 4
0010 E	RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962	.143	
0020 E	RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK		.01006	.011	
0030 E	KML-TA-HC	1.00 DIA 4.00-5.00 REM .033-.250		.08497	.097	
0040 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0165	JA 01	15	1.00 MACH CHAMFER	.240	.036	.276 4
0010 E	RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962	.143	
0020 E	RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK		.01006	.011	
0030 E	KML-TA-GC	1.00 DIA 3.00-4.00 REM .033-.250		.07800	.089	
0040 E	KML-TA-GD	1.00 DIA 4.0 REM .250 ADD INCH		.01707	.019	
0050 E	RJP-FW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001	.011	
0170	JA 01	15	1.00 MACH LOWER LIP	.240	.036	.276 4
0010 E	RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962	.143	
0020 E	RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK		.01006	.011	
0030 E	KML-TA-GC	1.00 DIA 3.00-4.00 REM .033-.250		.07800	.089	
0040 E	KML-TA-GD	1.00 DIA 4.0 REM .250 ADD INCH		.01707	.019	
0050 E	RJP-FW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001	.011	

0150	JA 01	15	1.00	DRILL HOLE	.072	.011	.034	1
0010 E		KML-CB-P1	1.00 CENTER DRILL		.01519		.017	
020 E		RSG-JP-03	1.00 PREP HAND DRILL FOR USE		.00861		.009	
030 E		RLA-DR-CA	1.00 DRILL HOLE 1/8-1/4 DIA ( 1/2		.03903		.044	
0040 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0181	JA 01	15	1.00	REIDENTIFY	.099	.015	.114	2
0010 E		RBW-SU-G1	.25 S/U FOR BENCH WORK GENERAL PRORATE OVER 4 PARTS		.27525		.079	
0020 E		GID-SA-A1	1.00 STAMP WITH METAL STAMP		.00342		.003	
0030 E		GID-SA-A2	9.00 STAMP W/METAL STAMP ADDL NINE ADDITIONAL NUMBERS		.00187		.019	
0040 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
9000	JA 01	00	.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0001			INITIAL INPUT, 9 JUNE 88					

TO INTERROGATE LABOR STANDARDS, INPUT

500 PRD NROP NR

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OPFR... TECH S S W F PF A/R REV

EP D L	T K	PR A	FA	SUPPORT	DCC	DESCRIPTION	BASE HOURS	PFD TIME	STD HOURS	DLY PCT
EP D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL				
RA503	S	E	JA	EA 1	J 88161	1.00 PERCENT ENGR 99.9 F-15 NLG PISTON	1.56		1.56	
0001			JA	01	00	.00 PART NUMBER/MSN	.000	.000	.000	0
0010						68A450704-1003 1620010232138				
0050			JA	01	15	.65 O/S HOLE ON MILL/SMALL PART	.675	.068	.520	33
0010 E						KMM-SU-V1 .25 S/U VERT MILL BORE SHAL EXTRAPRORATE OVER 4 PARTS	.50518		.145	
0020 E						RML-HP-CA 1.00 HAND HANDLE NO WRAP 2 CLAMPS	.06531		.098	
0030 E						RML-AL-AB 1.00 ALIGN VERTICAL AXIS ROD	.12699		.146	
0040 E						RML-AL-AC 1.00 ALIGN HOLE TO SPINDLE ROD	.07609		.087	
0050 E						RML-BD-AA 1.00 BORE HOLE 1 X 1/2 GROUP 4 USE PROPER ELEMENT/TABLE	.27100		.311	
0060 E						RJP-PW-R1 1.00 REM RPL PAPWRK SIGN OFF DCC	.01001		.011	
0060			JA	01	15	.65 POLISH I.D.	.029	.003	.022	1
0010 E						RSG-JP-05 1.00 PREP HAND DRILL CHANGE 1 BIT	.01603		.018	
0020 E						R3W-BU-P1 1.00 BUTTERFLY POLISH BUSHING I D	.00333		.003	
0030 E						RJP-PW-R1 1.00 REM RPL PAPWRK SIGN OFF DCC	.01001		.011	
0090			JA	01	15	.05 OVERSIZE HOLE WITH REAMER	.349	.003	.020	1
0010 E						R3W-BU-S1 .25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E						RLG-HP-V7 1.00 OBJ IN/OUT STP VISE-HST HAND	.06831		.078	
0030 E						R3W-BU-R2 3.00 REAM WITH LEMCO REAMER 3 PASSES	.07337		.253	
0040 E						R3W-DB-A1 1.00 DEBUR HOLE/CUTOUT BOTH SIDES	.00423		.004	
0050 E						RJP-PW-R1 1.00 REM RPL PAPWRK SIGN OFF DCC	.01001		.011	
0100			JA	01	15	.05 O/S HOLE ON MILL/SMALL PART	.695	.005	.040	3
0010 E						KMM-SU-V1 .25 S/U VERT MILL BORE SHAL EXTRAPRORATE OVER 4 PARTS	.50518		.145	
0020 E						RML-HP-CA 1.00 HAND HANDLE NO WRAP 2 CLAMPS	.06531		.098	
0030 E						RML-AL-AB 1.00 ALIGN VERTICAL AXIS ROD	.12699		.146	
0040 E						RML-AL-AC 1.00 ALIGN HOLE TO SPINDLE ROD	.07609		.097	
0050 E						RML-BD-AA 1.00 BORE HOLE 1 X 1/2 GROUP 4 USE PROPER ELEMENT/TABLE	.27100		.311	
0060 E						RJP-PW-R1 1.00 REM RPL PAPWRK SIGN OFF DCC	.01001		.011	
0418			JA	01	15	.87 TURN BUSHING GROUP 1/BRONZE	.289	.038	.289	19
0010 E						RLA-SU-S3 .25 SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143	
0020 E						RLA-HP-C1 2.00 1ST PART IN-OUT SCROLL CHUCK	.01006		.023	
0030 E						KML-TA-CC 2.00 DIA .501-1.00 REM .033-.250	.06699		.154	
0040 E						RJP-PW-R1 1.00 REM RPL PAPWRK SIGN OFF DCC	.01001		.011	
0420			JA	01	15	.87 INST/REAM SET FLANGED BUSH	.295	.039	.295	19
0010 E						R3W-BU-S1 .25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E						R3W-BU-B1 1.00 REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.274	
0030 E						RJP-PW-R1 1.00 REM RPL PAPWRK SIGN OFF DCC	.01001		.011	
0429			JA	01	15	.17 TURN BUSHING GROUP 1/BRONZE	.289	.007	.057	4
0010 E						RLA-SU-S3 .25 SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143	
0020 E						RLA-HP-C1 2.00 1ST PART IN-OUT SCROLL CHUCK	.01006		.023	
0030 E						KML-TA-CC 2.00 DIA .501-1.00 REM .033-.250	.06699		.154	
0040 E						RJP-PW-R1 1.00 REM RPL PAPWRK SIGN OFF DCC	.01001		.011	
0430			JA	01	15	.17 INST/REAM SET FLANGED BUSH	.295	.008	.058	4
0010 E						R3W-BU-S1 .25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E						R3W-BU-B1 1.00 REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.274	
0030 E						RJP-PW-R1 1.00 REM RPL PAPWRK SIGN OFF DCC	.01001		.011	
0439			JA	01	15	.39 TURN BUSHING GROUP 1/BRONZE	.289	.017	.130	8
0010 E						RLA-SU-S3 .25 SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143	
0020 E						RLA-HP-C1 2.00 1ST PART IN-OUT SCROLL CHUCK	.01006		.023	
0030 E						KML-TA-CC 2.00 DIA .501-1.00 REM .033-.250	.06699		.154	

0040 E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC	.01001	.011
0440	JA 01 15	.39	INST/REAM SET FLANGED BUSH	.295	.017 .132
0010 E	RBM-BU-S1	.25	SET UP TO REBUSH BOSSES	.18669	.053
0020 E	RBM-BU-B1	1.00	REBUSH A SET OF 2 BOSSES	.23335	.274
0030 E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC	.01001	.011
	JA 01 00	.01	LABOR STANDARD HISTORY	.000	.000 .000
0001	KIM VINCENT, MANEL, 73255				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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17402A F-15 DAMPER; PISTON

RCC NNPRB

9H2-3-83-3

85231

TECH S S W F PF A/R REV

T K #R A FA SUPPORT

OCC

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DESCRIPTION

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BASE

PFD

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P D L K C DC ELEMENT

FACT

STORED

SUPPLEMENTAL

HOURS

TIME

HOURS

DLY PCT C

B501	S	E	JA	EA	3	J	88098	.92	PERCENT ENGR 99.9	GRD.REPR.OTR.CYL.F-15NLS	9.08		8.36		
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010									68M450602-1001	1620003109830					
0099			JA	01	15			1.00		POLISH UPPER BORE	.495	.074	.570		6
0010	E						RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316		
0020	E						ZPO-BP-C2	1.00	BUTTERFLY POLISH CYL I.D.		.15445		.177		
0030	E						ZIT-VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.064		
0040	E						RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0100			JA	01	15			.95		HONE UPPER BORE	3.271	.466	3.574		39
0010	E						RHO-HP-L1	.50	LOAD UNLOAD HONE WITH HOIST 2 AREAS		.17802		.102		
0020	E						RHO-SU-V1	.50	SET UP LARGE VERTICAL HONE 2 AREAS		.55195		.317		
0030	E						KMG-ID-JE	6.00	GRIND OUT .010-4 IN ID X 3 HONE I.D.		.48265		3.330		
0040	E						BIT-BI-01	1.00	INSP - TEST BORE IND GAGE		.00020		.000		
0050	E						RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0101			JA	01	15			1.00		POLISH LOWER BORE	.495	.074	.570		6
0010	E						RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316		
0020	E						ZPO-BP-C2	1.00	BUTTERFLY POLISH CYL I.D.		.15445		.177		
0030	E						ZIT-VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.064		
0040	E						RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0102			JA	01	15			1.00		HONE LOWER BORE	1.823	.273	2.097		23
0010	E						RHO-HP-L1	.50	LOAD UNLOAD HONE WITH HOIST 2 AREAS		.17802		.102		
0020	E						RHO-SU-V1	.50	SET UP LARGE VERTICAL HONE 2 AREAS		.55195		.317		
0030	E						KMG-ID-JE	3.00	GRIND OUT .010-4 IN ID X 3 HONE I.D.		.48265		1.665		
0040	E						BIT-BI-01	1.00	INSP - TEST BORE IND GAGE		.00020		.000		
0050	E						RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0140			JA	01	15			1.00		POLISH UPPER BORE	.495	.074	.570		6
0010	E						RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316		
0020	E						ZPO-BP-C2	1.00	BUTTERFLY POLISH CYL I.D.		.15445		.177		
0030	E						ZIT-VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.064		
0040	E						RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0145			JA	01	15			1.00		POLISH LOWER BORE	.495	.074	.570		6
0010	E						RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316		
0020	E						ZPO-BP-C2	1.00	BUTTERFLY POLISH CYL I.D.		.15445		.177		
0030	E						ZIT-VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.064		
0040	E						RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0177			JA	01	15			1.00		POLISH UPPER BORE	.495	.074	.570		6
0010	E						RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316		
0020	E						ZPO-BP-C2	1.00	BUTTERFLY POLISH CYL I.D.		.15445		.177		
0030	E						ZIT-VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.064		
0040	E						RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0179			JA	01	15			1.00		POLISH LOWER BORE	.495	.074	.570		6
0010	E						RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316		
0020	E						ZPO-BP-C2	1.00	BUTTERFLY POLISH CYL I.D.		.15445		.177		
0030	E						ZIT-VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.064		
0040	E						RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
9000			JA	00	00			.00		LABOR STANDARD HISTORY	.000	.000	.000		0
0010									7 APRIL 88 INITIAL INPUT/NEW WORKLOAD						
0900									KERRY COOP MANEL TECHN 73357						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

&lt;-X--X--X--&gt;

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS  
RCC MNPRB

12/02/88  
9H2-3-83-3

A-E046B-NM1-DY-M45 PAGE 0001  
85231

17402A F-15 DAMPER; PISTON

CH S S W F PF A/R REV

T K #R A FA SUPPORT

STEP D L K C DC ELEMENT

OCC

FACT

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DESCRIPTION

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BASE

HOURS

PFD

TIME

STD

HOURS

A

DLY PCT C

RB503	S	N	JA	EA	3	K	88161	.26	PERCENT ENGR 65.1	GRD REPAIR PISTON	9.66		2.51		
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010									68A450704-1003	1620010232138					
0065			JA	01	00			.00			.406	.000	.000		0
0010 E							RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.275		
0020 E							ZPO-BP-C1	1.00	BUTTERFLY POLISH SM CYL I.D.		.06549		.065		
0030 E							ZIT-VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.055		
0040 E							RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.010		
0070			JA	01	00			.00			.406	.000	.000		0
0010 E							RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.275		
0020 E							ZPO-BP-C1	1.00	BUTTERFLY POLISH SM CYL I.D.		.06549		.065		
0030 E							ZIT-VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.055		
0040 E							RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.010		
0075			JA	01	00			1.00			.406	.000	.407		4
0010 E							RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.275		
0020 E							ZPO-BP-C1	1.00	BUTTERFLY POLISH SM CYL I.D.		.06549		.065		
0030 E							ZIT-VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.055		
0040 E							RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.010		
0120			JA	01	15			.33		1ST GRIND PISTON OD-050- PRORATE 2 PARTS	1.929	.096	.732		8
0010 E							RGR-SU-G1	.50	SET UP A GAP GRINDER		1.05938		.609		
0020 E							RGR-HP-L4	1.00	LOAD LARGE PART GAP GR FIXTR		.30830		.354		
0030 E							RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0040 E							RGR-GE-S2	70.00	GR STEEL OD (OCC FACT L X D) 3.5 X 20 IN		.01093		.879		
0050 E							RGR-GE-D2	3.50	DWELL (GAP GRINDER STEEL OD) 3.5 DIA		.01014		.040		
0060 E							RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER		.08334		.095		
0070 E							RGR-HM-C4	1.00	HANDLE & MEAS LENGTH 12 - 24		.10674		.122		
0080 E							RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011		
0130			JA	01	15			.50		1ST GRD INNER JRNL -060-	.876	.066	.504		5
0010 E							RGR-SU-G1	.50	SET UP A GAP GRINDER	2 JRNL	1.05938		.609		
0020 E							RGR-HP-L4	.50	LOAD LARGE PART GAP GR FIXTR	2 JRNL	.30830		.177		
0030 E							RLA-HP-C3	.50	CHUCK SYMET PART IN 4 JAW	2 JRNL	.09095		.052		
0040 E							RGR-GE-S2	2.23	GR STEEL OD (OCC FACT L X D) 2.23 X 1 IN		.01093		.028		
0050 E							RGR-GE-D2	2.23	DWELL (GAP GRINDER STEEL OD) 2.23 DIA		.01014		.026		
0060 E							RGR-WD-G2	.50	WHEEL DRESS GAP GRINDER	2 JRNL	.08334		.047		
0070 E							RGR-HM-C4	.50	HANDLE & MEAS LENGTH 12 - 24	2 JRNL	.10674		.061		
0080 E							RJP-PW-R1	.50	REM RPL PAPWRK SIGN OFF DOC	2 PLACES	.01001		.005		
0140			JA	01	15			.50		1ST GRD OUTER JRNL -070-	.875	.066	.504		5
0010 E							RGR-SU-G1	.50	SET UP A GAP GRINDER	2 JRNL	1.05938		.609		
0020 E							RGR-HP-L4	.50	LOAD LARGE PART GAP GR FIXTR	2 JRNL	.30830		.177		
0030 E							RLA-HP-C3	.50	CHUCK SYMET PART IN 4 JAW	2 JRNL	.09095		.052		
0040 E							RGR-GE-S2	2.20	GR STEEL OD (OCC FACT L X D) 2.20 X 1 IN		.01093		.027		
0050 E							RGR-GE-D2	2.20	DWELL (GAP GRINDER STEEL OD) 2.20 DIA		.01014		.025		
0060 E							RGR-WD-G2	.50	WHEEL DRESS GAP GRINDER	2 JRNL	.08334		.047		
0070 E							RGR-HM-C4	.50	HANDLE & MEAS LENGTH 12 - 24	2 JRNL	.10674		.061		
0080 E							RJP-PW-R1	.50	REM RPL PAPWRK SIGN OFF DOC	2 PLACES	.01001		.005		
0145			JA	01	00			1.00			1.103	.000	1.104		11
0010 E							RHO-HP-L1	1.00	LOAD UNLOAD HOME WITH HOIST		.17802		.178		
0020 E							RHO-SU-V1	1.00	SET UP LARGE VERTICAL HOME		.55195		.551		
0030 E							KMG-ID-GE	1.00	GRIND OUT .010 3 ID X 3		.36332		.363		

0040 E	BIT-BI-01	1.00	INSP - TEST BORE IND GAGE	.00020	.000	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.010	
0280	JA 01 15	.50	FINISH GRD INN JRNL-190-	.923	.069	5
010 E	RGR-SU-G1	.50	SET UP A GAP GRINDER 2 JRNL	1.05938	.609	
020 E	RGR-HP-L4	.50	LOAD LARGE PART GAP GR FIXTR 2 JRNL	.30830	.177	
0030 E	RLA-HP-C3	.50	CHUCK SYNET PART IN 4 JAW 2 JRNL	.09095	.052	
0040 E	RGR-GE-C2	2.23	GR CHROM OD (OCC FACT L X D) 2.23 X 1 IN	.02189	.056	
0050 E	RGR-GE-D3	2.23	DWELL (GAP GRINDER CHROM OD) 2.23 DIA	.02029	.052	
0060 E	RGR-WD-G2	.50	WHEEL DRESS GAP GRINDER 2 JRNL	.08334	.047	
0070 E	RGR-HM-C4	.50	HANDLE & MEAS LENGTH 12 - 24 2 JRNL	.10674	.061	
0080 E	RJP-PW-R1	.50	REM RPL PAPWRK SIGN OFF DOC 2 PLACES	.01001	.005	
0290	JA 01 15	.50	FINISH GRD OUT JRNL-200-	.922	.069	5
0010 E	RGR-SU-G1	.50	SET UP A GAP GRINDER 2 JRNL	1.05938	.609	
0020 E	RGR-HP-L4	.50	LOAD LARGE PART GAP GR FIXTR 2 JRNL	.30830	.177	
0030 E	RLA-HP-C3	.50	CHUCK SYNET PART IN 4 JAW 2 JRNL	.09095	.052	
0040 E	RGR-GE-C2	2.20	GR CHROM OD (OCC FACT L X D) 2.20 X 1 IN	.02189	.055	
0050 E	RGR-GE-D3	2.20	DWELL (GAP GRINDER CHROM OD) 2.20 DIA	.02029	.051	
0060 E	RGR-WD-G2	.50	WHEEL DRESS GAP GRINDER 2 JRNL	.08334	.047	
0070 E	RGR-HM-C4	.50	HANDLE & MEAS LENGTH 12 - 24 2 JRNL	.10674	.061	
0080 E	RJP-PW-R1	.50	REM RPL PAPWRK SIGN OFF DOC 2 PLACES	.01001	.005	
0300	JA 01 15	.33	FINISH GRD PISTN O.D.	2.732	.135	11
0010 E	RGR-SU-G1	.50	SET UP A GAP GRINDER PRORATE 2 PARTS	1.05938	.609	
0020 E	RGR-HP-L4	1.00	LOAD LARGE PART GAP GR FIXTR	.30830	.354	
0030 E	RLA-HP-C3	1.00	CHUCK SYNET PART IN 4 JAW	.09095	.104	
0040 E	RGR-GE-C2	70.00	GR CHROM OD (OCC FACT L X D) 3.5 X 20 IN	.02189	1.762	
0050 E	RGR-GE-D3	3.50	DWELL (GAP GRINDER CHROM OD) 3.5 DIA	.02029	.081	
0060 E	RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER	.08334	.095	
0070 E	RGR-HM-C4	1.00	HANDLE & MEAS LENGTH 12 - 24	.10674	.122	
0080 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
	JA 01 15	1.00	GRIND CHROME I.D.	3.757	.564	45
0010 E	RGR-SU-I1	.25	S/U SMALL INTERNAL GRINDER PRORATE OVER 4 PARTS	.49838	.143	
0020 E	RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK	.22097	.254	
0030 E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	.02632	.030	
0040 E	KMG-DW-ID	4.00	DRESS INTERNAL WHEEL	.02458	.113	
0050 E	KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION	.06761	.077	
0060 H		1.00	GRD CHROM I.D. .040-3.2 X 36	3.00000	3.450	
0070 E	RGR-GE-D3	3.50	DWELL (GAP GRINDER CHROM OD)	.02029	.081	
0080 E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5	.08102	.093	
0090 E	ZIT-VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.	.05578	.064	
0100 E	RBW-BU-P1	.50	BUTTERFLY POLISH BUSHING I D	.00333	.001	
0110 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
9000	JA 01 15	.01	LABOR STANDARD HISTCRY	.000	.000	0
0010			04MAR83 HATCH UP SUB OPS TO FORM 470			
0020			04MAR83 UPDATE OPER LINE & OCC FACTORS 00570			
0030			17AUG83 REVIEW AND CHG OCC. FACTORS			
0040			PREVIOUS STD HRS 0.56			
0045			11SEPT84 OCC ADJUST <OLD STD> 1.27			
0046			10OCT84 ADDED PR&D OLD TIME 71			
0047			6 NOV84 2 YR REVIEW W/OCC CHANGE .79			
0048			23JULY85 CHANGED SUB OP TO MATCH 958 NO TIME CHANG			
0049			28AUG85 OCC FACTOR CHANGE OLD STD .96			
0900			J.CALDWELL TECH MANEAA			

ERROGATE LABOR STANDARDS, INPUT

17402A F-15 DAMPER; PISTON

RCC HNFRB

942-3-93-3

95231

PAGE 0001

OPER TECH S S W F PF A/R REV

TK #R A FA SUPPORT

STEP D L K C DC ELEMENT

DCC

**FACT**

STORED

DESCRIPTION : [REDACTED]

**SUPPLEMENTAL**

BASE  
HOURS

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HOURS

A  
DLY PCT C

E3506	S	E	JA	EA	J	88160	.05 PERCENT ENGR 99.9	GRIND CRANK STEERING	.52		.02	
0001			JA	01		00	.00	PART NUMBER/MSN	.000	.000	.000	0
0C10							68A450610-2003	1620003109834				
0040			JA	01		15	1.00	1ST GRIND BOSS O.D.-040-	.225	.034	.09	50
0010 E			RGR-SU-J2				.20 S-U JIG GRINDER LRG FIX-TBLE PRORATE 5 PARTS		.80167		.184	
0020 E			KMG-DW-OD				1.00 DRESS EXTERNAL WHEEL		.02308		.026	
0030 E			KMG-OB-CA				1.00 GRIND .010 1 OD X 1		.03200		.036	
0040 E			RJP-PW-R1				1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0110			JA	01		15	1.00	FINSH GRD BOSS O.D.-110-	.229	.034	.264	50
0010 E			RGR-SU-J2				.20 S-U JIG GRINDER LRG FIX-TBLE PRORATE 5 PARTS		.80167		.184	
0020 E			KMG-DW-OD				1.00 DRESS EXTERNAL WHEEL		.02308		.026	
0030 E			KMG-OB-AF				1.00 GRIND .040 FROM 1/20 X 1		.03633		.041	
0040 E			RJP-PW-R1				1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
9000			JA	01		15	.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010							24FEB83 UPGRADE TO E STD CHG OCC FACTORS	14000				
0020							17AUG83 REVIEW AND CHG OCC. FACTORS					
0030							PREVIOUS STD HRS 0.19					
0035							12SEPT84 OCC ADJUST <OLD STD>	.02				
0036							10OCT84 ADDED PR&D TIME OLD STD	02				
0037							6 NOV84 2 YR REVIEW W/OCC CHANGE < OLD STD >	.02				
0038							23JULY85 CHANGED SUB OP TO MATCH 958 NO TIME CHANG					
0900							J.CALDWELL TECH MANEAA					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRCF NB

$$(-\infty, -\frac{1}{2}) \cup (-\frac{1}{2}, \frac{1}{2}) \cup (\frac{1}{2}, \infty)$$

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## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

06/24/88

A-E046B-MM1-DY-M45 PAGE 0001

17-02A F-15 DAMPER; PISTON

RCC MNPR

9H2-3-83-3

85231

OPER TECH S S W F PF A/R REV

T K #R A FA SUPPORT

OCC

-----&gt; DESCRIPTION -----&gt;

BASE

PFD

E'D

A

JEP D L K C DC ELEMENT

FACT

STORED

SUPPLEMENTAL

HOURS

TIME

HOURS

DLY PCT C

88513	S	E	JA	EA	3	J	88160	1.00	PERCENT ENGR 99.9	GRIND UP STEERING BOLT F-15	1.29		1.29		
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010									68A450625-2001	5306003291614					
0070			JA	01	15			1.00		1ST GRIND O.D.	.642	.096	.739		57
0010	E						RGR-SU-C2	1.00	SET UP SMALL MED CYL GRINDER		.29197		.335		
0020	E						RLA-HP-C3	1.00	CHUCK SYNET PART IN 4 JAW		.09095		.104		
0030	E						RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E						KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E						KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E						KMG-OD-CE	1.00	GRIND .010 1 OD X 3		.08533		.098		
0070	E						RGR-GE-02	1.00	DWELL (GAP GRINDER STEEL OD) OCCURRED FOR DIA		.01014		.011		
0080	E						RTL-MM-M3	6.00	MIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042		
0090	E						RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0140			JA	01	15			1.00		GRIND CHROME O.D.	.485	.073	.558		43
0010	E						RGR-SU-C2	.25	SET UP SMALL MED CYL GRINDER PRORATE OVER 4 PARTS		.29197		.083		
0020	E						RLA-HP-C3	1.00	CHUCK SYNET PART IN 4 JAW		.09095		.104		
0030	E						RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E						KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E						KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E						KMG-OD-CK	1.00	GRIND .040 1 OD X 3		.13734		.157		
0070	E						RGR-GE-D3	1.00	DWELL (GAP GRINDER CHROM OD) OCCURRED FOR DIA		.02029		.023		
0080	E						RTL-MM-M3	6.00	MIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042		
0090	E						RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
			JA	00	00			.00		LABOR STANDARD HISTORY	.000	.000	.000		0
010									6 APRIL 88 TIME COORDINATED WITH FRMN K. STEPHENS						
0900									KERRY COOP MANEL TECHN 73357						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NR

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0010 E		RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316	
0020 E		RLG-EI-AC	1.00	CHECK ALIGNMENT		.06483		.074	
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0064	JA 01	15	.05	GRIND CHROME O.D.		.437	.003	.025	0
0010 E		RGR-SU-C2	.25	SET UP SMALL MED CYL GRINDER PRORATE OVER 4 PARTS		.29197		.083	
0020 E		RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0030 E		RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0040 E		KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026	
0050 E		KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077	
0060 E		KMG-OD-DF	1.00	GRIND .040 1 1/2 OD X 1		.07883		.090	
0070 E		RGR-GE-D3	1.50	DWELL (GAP GRINDER CHROM OD) OCCURRED FOR DIA		.02029		.035	
0080 E		RTL-MM-M3	6.00	HIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042	
0090 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0069	JA 01	15	.05	CHECK CTRLINE TO RACEWAY		.350	.003	.020	0
0010 E		RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316	
0020 E		RLG-EI-AC	1.00	CHECK ALIGNMENT		.06483		.074	
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0070	JA 01	00	.90	FIRST GRIND		.672	.000	.605	9
0010 E		RGR-SU-J1	.25	S/U JIG GRINDER SHL FIXTURE PRORATED OVER 4 PARTS		.75732		.189	
0020 E		PYL-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.119	
0030 E		RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.026	
0040 E		KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.023	
0050 E		KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.067	
0060 E		RLA-PT-GC	4.00	MACH TIME 25 SFPM .007 FEED		.02506		.100	
0070 E		RGR-GE-C2	6.00	GR CHROM OD (OCC FACT L X D)		.02189		.131	
0080 E		RTL-MM-M1	1.00	MIKE ID OR 2 FLAT SURFACES		.00481		.004	
0090 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.010	
0080	JA 01	00	.25	FIRST GRIND		1.722	.000	.431	6
0010 E		RGR-SU-S1	.25	SET UP SURFACE GRINDER PRORATED OVER 4 PARTS		.04390		.010	
0020 E		RML-SU-F3	1.00	LRG FIXTUR TO/FRM MACH HOIST		.45621		.456	
0030 E		RLA-HP-C6	1.00	LOAD/UNLOAD SHL PART-CENTERS		.02466		.024	
0040 E		RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.026	
0050 E		KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.023	
0060 E		RGR-GE-D3	1.00	DWELL (GAP GRINDER CHROM OD)		.02029		.020	
0070 E		KMG-GW-LK	4.00	LOCATE WHEEL TO POSITION		.06761		.270	
0080 E		RGR-GE-C2	40.00	GR CHROM OD (OCC FACT L X D)		.02189		.375	
0090 E		RTL-MM-M1	1.00	MIKE ID OR 2 FLAT SURFACES		.00481		.004	
0100 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.010	
0150	JA 01	00	.90	FIRST GRIND		.686	.000	.618	9
0010 E		RGR-SU-J1	.25	S/U JIG GRINDER SHL FIXTURE PRORATED OVER 4 PARTS		.75732		.189	
0020 E		RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.119	
0030 E		RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.026	
0040 E		KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.023	
0050 E		KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.067	
0060 E		RLA-PT-GC	4.00	MACH TIME 25 SFPM .007 FEED		.02506		.100	
0070 E		RGR-GE-C2	6.00	GR CHROM OD (OCC FACT L X D)		.02189		.131	
0080 E		RTL-MM-M1	4.00	MIKE ID OR 2 FLAT SURFACES		.00481		.019	
0090 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.010	
0153	JA 01	00	.90	FIRST GRIND		1.722	.000	1.550	22
0010 E		RGR-SU-S1	.25	SET UP SURFACE GRINDER PRORATED OVER 4 PARTS		.04390		.010	
0020 E		RML-SU-F3	1.00	LRG FIXTUR TO/FRM MACH HOIST		.45621		.456	
0030 E		RLA-HP-C6	1.00	LOAD/UNLOAD SHL PART-CENTERS		.02466		.024	
0040 E		RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.026	
0050 E		KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.023	
0060 E		RGR-GE-D3	1.00	DWELL (GAP GRINDER CHROM OD)		.02029		.020	
0070 E		KMG-GW-LK	4.00	LOCATE WHEEL TO POSITION		.06761		.270	

0080 E	RGR-GE-C2	40.00	GR CHROM OD (OCC FACT L X D)	.02189	.875	
0090 E	RTL-MM-M1	1.00	MIKE ID OR 2 FLAT SURFACES	.00481	.004	
0100 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001	.010	
0162	JA 01	00	.25 FIRST GRIND	1.722	.000	.431 6
0010 E	RGR-SU-S1	.25	SET UP SURFACE GRINDER	.04390	.010	
0020 E	RML-SU-F3	1.00	LRG FIXTUR TO/FRM MACH HOIST	.45621	.456	
30 E	RLA-HP-C6	1.00	LOAD&UNLOAD SML PART-CENTERS	.02466	.024	
0040 E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	.02632	.026	
0050 E	KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL	.02308	.023	
0060 E	RGR-GE-D3	1.00	DWELL (GAP GRINDER CHROM OD)	.02029	.020	
0070 E	KMG-GW-LK	4.00	LOCATE WHEEL TO POSITION	.06761	.270	
0080 E	RGR-GE-C2	40.00	GR CHROM OD (OCC FACT L X D)	.02189	.875	
0090 E	RTL-MM-M1	1.00	MIKE ID OR 2 FLAT SURFACES	.00481	.004	
0100 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001	.010	
0249	JA 01	15	1.00 VERTICAL OR HORIZONTAL HONE	.172	.026	.198 3
0010 E	RHO-SU-V1	.10	SET UP LARGE VERTICAL HONE	.55195	.063	
0020 E	RML-SU-F3	.10	LRG FIXTUR TO/FRM MACH HOIST	.45621	.052	
0030 N		.10	LOAD & UNLOAD PART	.12200	.014	
0040 N		.10	HONE	.30000	.034	
0050 E	RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT	.01603	.018	
0060 E	RBW-BU-P1	1.00	BUTTERFLY POLISH BUSHING I D	.00333	.003	
0070 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001	.011	
9000	JA 01	15	.01 LABOR STANDARD HISTORY	.000	.000	.000 0
0010			17AUG83 REVIEW AND CHG OCC. FACTORS			
0020			PREVIOUS STD HRS 0.73			
0030			08MAR84 REVIEW SUB OPR 030/1.045/050/.931 OLD STD			
0040			04APR84 OPR 1/30 ADDED FOR REROUTE OF ITEM 16 % IS			
0041			28AUG85 OCC FACTOR CHANGE & ADDED 0154 O/STD 2.46			
0050			EST ONLY NO HISTORY			
0055			12SEPT84 OCC ADJUSTD <OLD STD>3.70			
0056			10OCT84 ADDED PF&D TIME < OLD STD> 1058			
0057			6 NOV84 2 YR REVIEW W/OCC CHANGE < OLD STD > 9.53			
758			10JULY85 ADDED TIME SUB OF 0007 OLD STD 2.45			
0059			22JULY CHANGED STD TO MATCH 958 NO TIME CHANGE			
0900			J.CALDWELL TECH MANEAA			

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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KC-135 NLG

G284 Cannon

James L. Leland

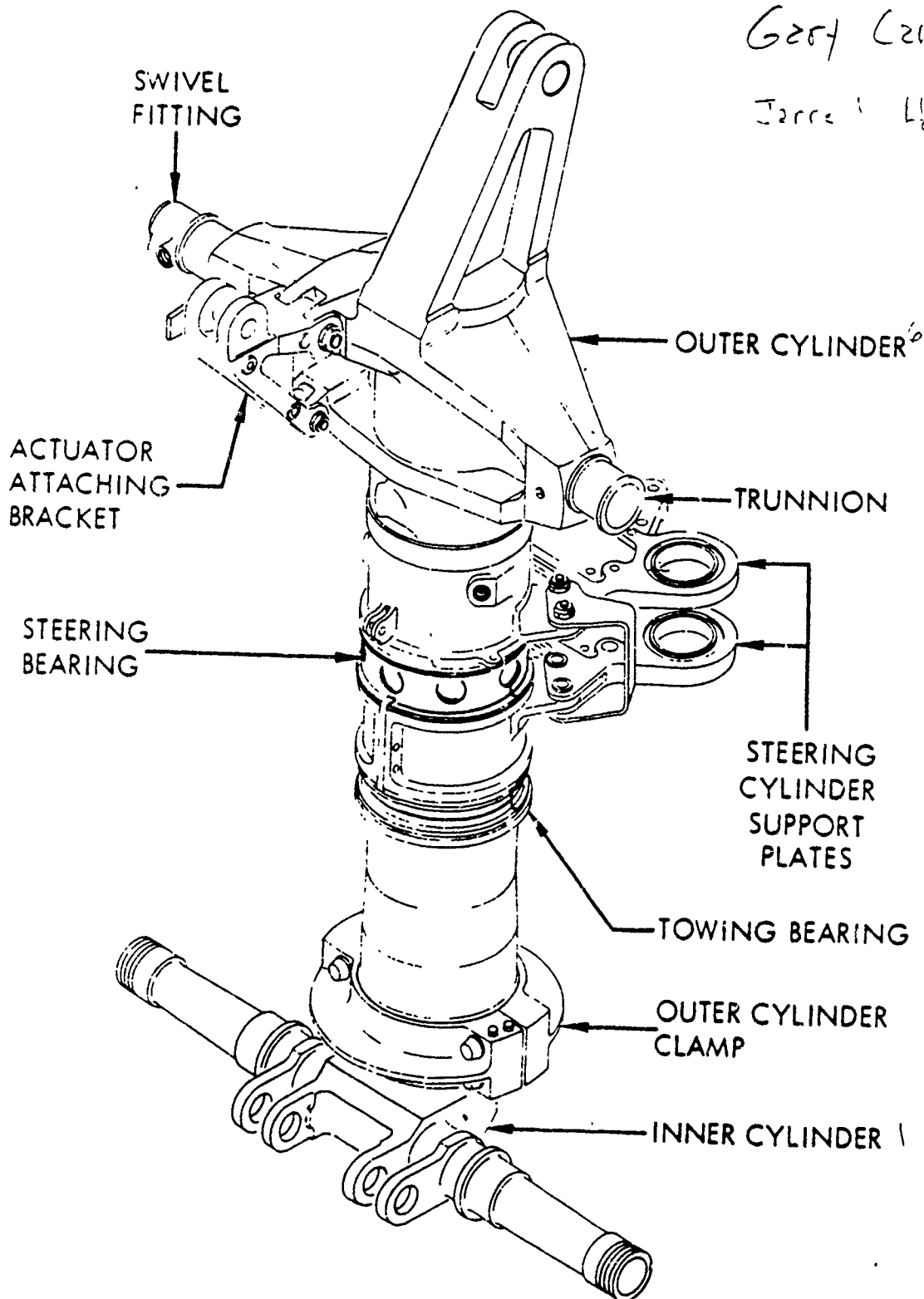


Figure 1-2. Nose Gear Oleo and Collar Assembly

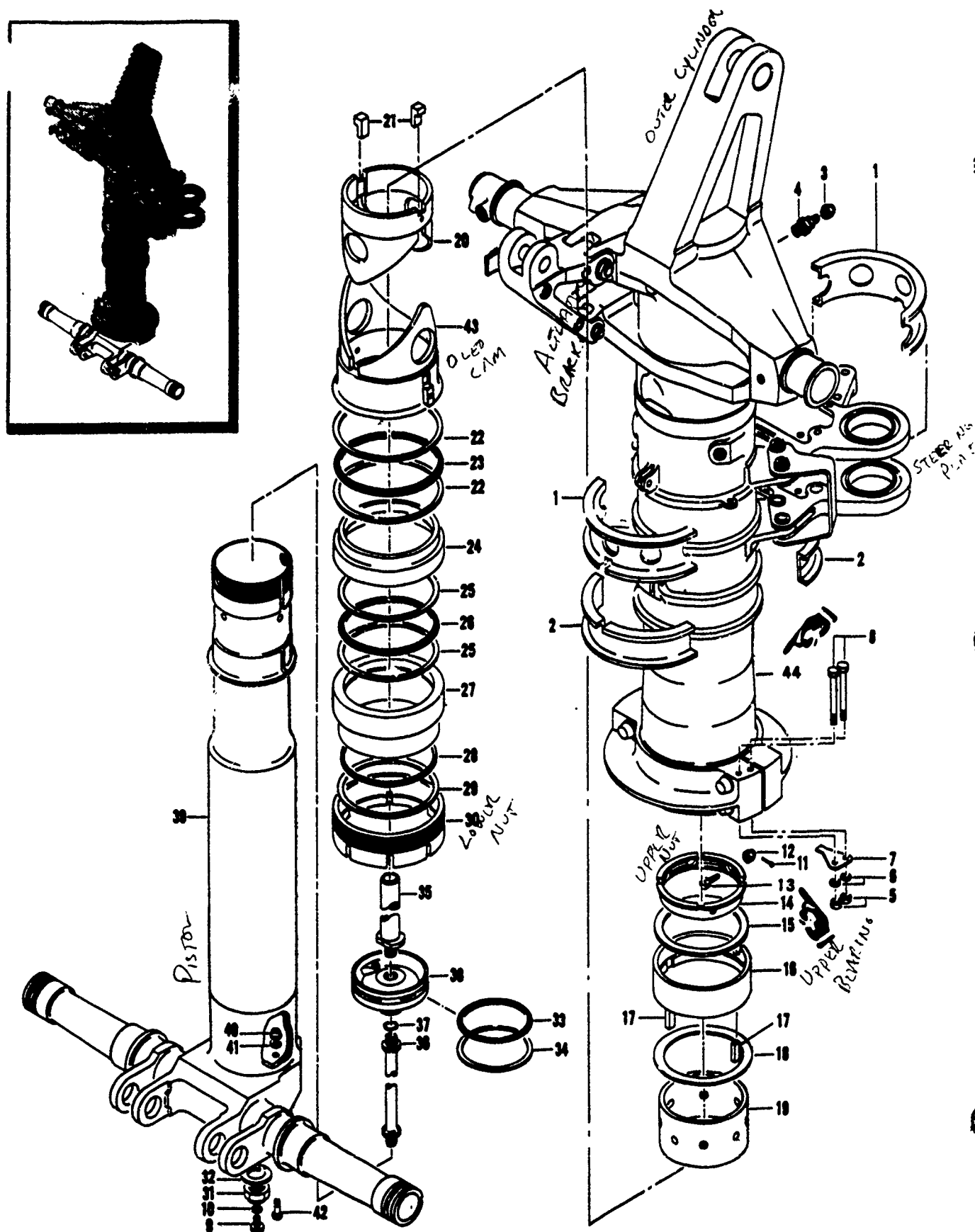


Figure 2-2. Nose Gear Oleo and Collar Assembly (Sheet 1 of 2)

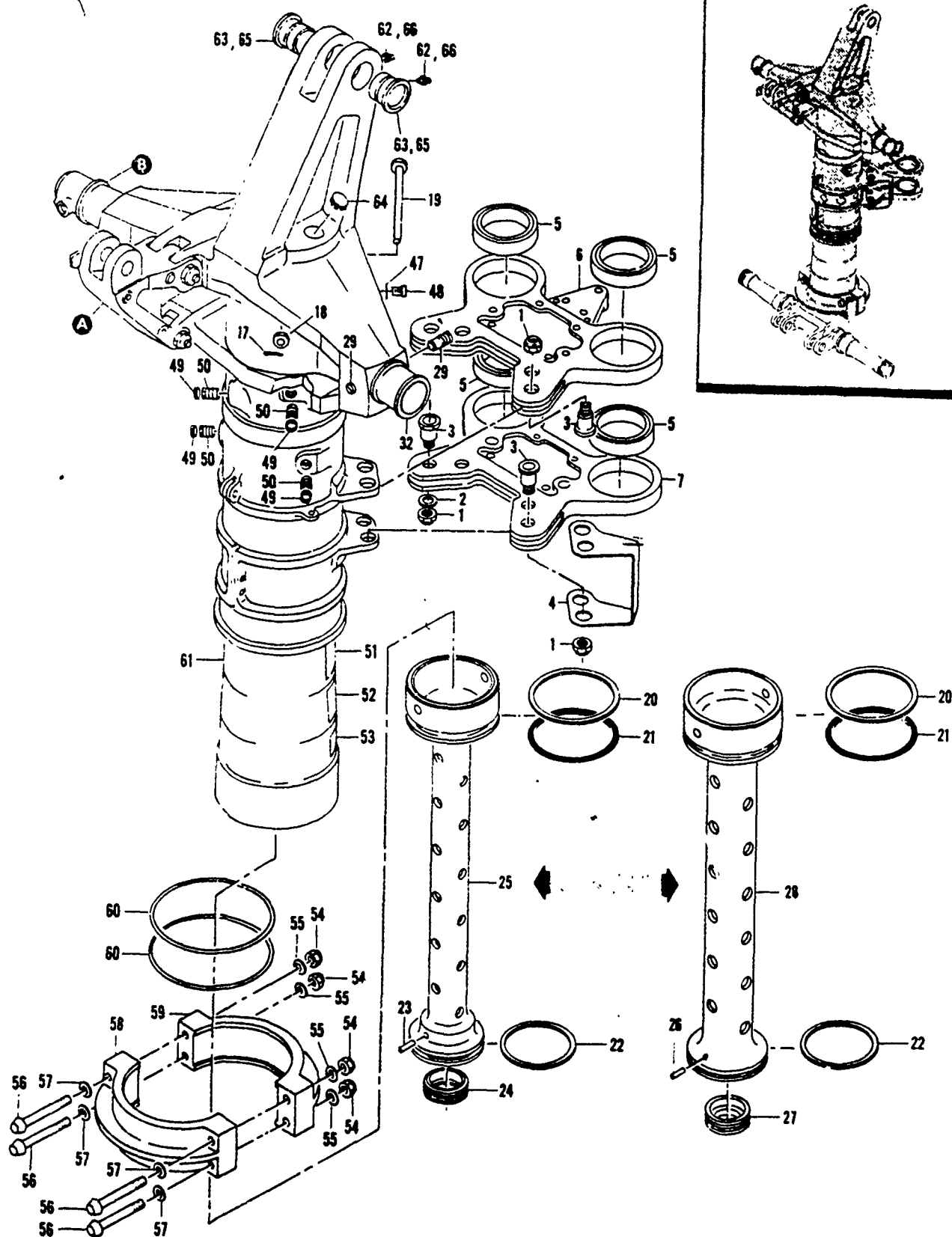


Figure 2-3. Nose Gear Outer Cylinder Assembly (Sheet 1 of 2)

## KEY TO FIGURE 2-3

1 NUT	14 BOLT	27 PLATE	40 FITTING	53 METAL-CAL
2 WASHER	15 WASHER	28 TUBE	41 PLUG	54 NUT
3 PIN	16 BRACKET	29 SCREW	42 FITTING	55 WASHER
4 BRACKET	17 PIN	30 NUT	43 TRUNNION PIN	56 BOLT
5 BEARING	18 NUT	31 SCREW	44 BOLT	57 WASHER
6 PLATE	19 BOLT	32 TRUNNION	45 BRACKET	58 CLAMP HALF
7 PLATE	20 RING	33 PIN	46 SLEEVE	59 CLAMP HALF
8 NUT	21 PACKING	34 WASHER	47 PACKING	60 PACKING
9 NUT	22 RING	35 FITTING	48 FITTING	61 OUTER CYLINDER
10 WASHER	23 PIN	36 RING	49 RING	62 FITTING
11 WASHER	24 PLATE	37 PACKING	50 SLEEVE	63 BUSHING
12 BOLT	25 TUBE	38 PIN	51 METAL-CAL	64 PLUG
13 WASHER	26 PIN	39 PLUG	52 METAL-CAL	65 BUSHING
				66 FITTING

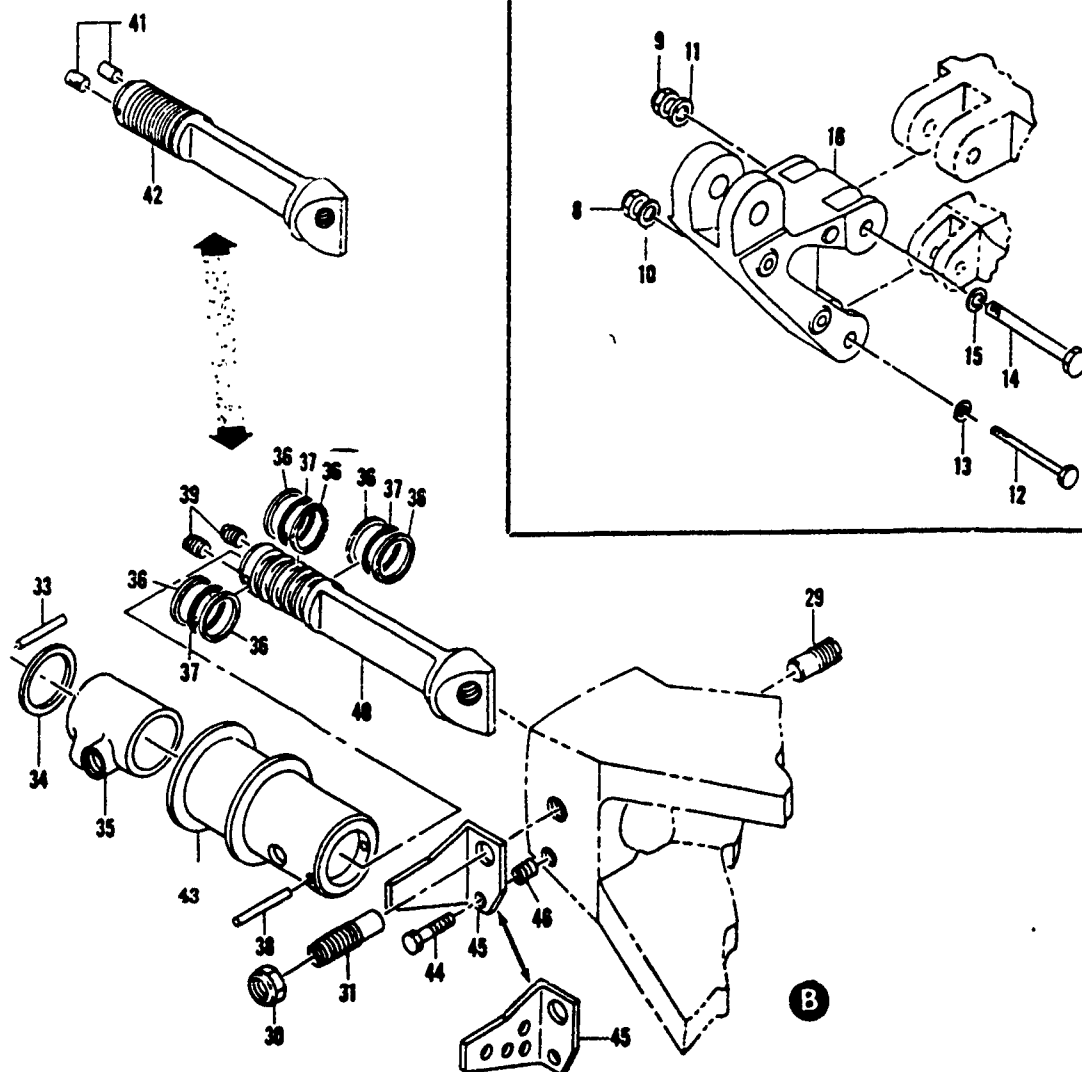


Figure 2-3. Nose Gear Outer Cylinder Assembly (Sheet 2 of 2)

# SECTION X

## MAINTENANCE PARTS LIST

### NOTE

This parts list reflects the user with most replacement parts usable at major overhaul and at minor repair. Standard parts, and parts having multiapplication, are stocked in their appropriate class.

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
10-1-	5-83069-8	81205	OLEO ASSEMBLY, NOSE GEAR (Parts ..... kits available)	REF		
	7327025-30	98747	OLEO ASSEMBLY, NOSE GEAR .....	REF		
	7327025-50	98747	OLEO ASSEMBLY, NOSE GEAR .....			PAODD
	7327025-110	98747	OLEO ASSEMBLY, NOSE GEAR .....			PAODD
-1	9-55604-2	81205	BEARING ASSEMBLY, Steering knuckle..... for bearing land width 3.252/3.255 (standard)	1		PAODD
	9-55604-4	81205	BEARING ASSEMBLY, Steering knuckle..... for bearing land width 3.352/3.335 (oversize)	1		PAODD
-2	9-55608-2	81205	BEARING ASSEMBLY, Towing collar for ..... bearing land width 1.877/1.880 (stan- dard)	1		PAODD
	90-6715-6	81205	BEARING ASSEMBLY, Towing collar for ..... bearing land width 2.228/2.230 (over- size)	1		PAODD
	5-83069-4	81205	OLEO ASSEMBLY, Nose gear (use..... with 90-6715-6 and 9-55604-4)	1		PAODD
	5-83069-6	81205	OLEO ASSEMBLY, Nose gear (use..... with 69-11369 and 69-11370)	REF		
	5-83069-7	81205	OLEO ASSEMBLY, Nose gear (use..... with 90-6715-6 and 9-55604-4)	1		PAODD
-2a	52-032-156-1000	72962	PIN, Spring steel (BAC P18 ..... L10P1000)	4		PAOZZ
-2b	3-95606	81205	KEY, Nose gear steering bearing .....	2		PAOZZ
-3	AN813-1B	80205	CAP, Protective, dust and ..... moisture seal	1		PAOZZ
-4	MS28889-1	80205	VALVE, Stop check (preferred) .....	1		PAOZZ
	AN6287-1	80205	VALVE, Stop check .....	1		PAOZZ
-5	AN3-33A	80205	BOLT .....	2		PAOZZ
-6	NAS679-A3W	80205	NUT .....	2		PAOZZ
-7	AN960C10L	80205	WASHER .....	2		PAOZZ
-8	63-10418-1	81205	LOCKING KEY .....	1		PAOZZ
	5-83069-1	81205	INNER CYLINDER ASSEMBLY, ..... Nose gear	1		PAODD
	5-83069-3	81205	INNER CYLINDER ASSEMBLY, ..... Nose gear	1		PAODD
-9	AN814-6L	88044	PLUG, Machine thread .....	1		PAOZZ
-10	MS28778-6	88044	PACKING (Optional..... AN6227B10)	1		PAOZZ
	AN6227B10	88044	PACKING .....	1		PAOZZ
-11	AN380-2-2	88044	PIN, Cotter .....	1		PAOZZ
-12	AN320-4	88044	NUT .....	1		PAOZZ
-13	60-6656	81205	PIN, Nut retainer .....	1		PAOZZ
-14	60-6681	81205	NUT, Nose gear upper oleo ..... bearing (optional 60-6681-1)	1		PAOZZ
	60-6681-1	81205	NUT, Nose gear upper oleo ..... bearing	1		PAOZZ
	60-6681-2	81205	NUT, Nose gear upper oleo ..... bearing (preferred)	1		PAOZZ
-15	60-6619-1	81205	WASHER, Nose gear oleo..... upper, 0.040	AR		

T.O. 4S2-30-3

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION							UNITS PER ASSY	USABLE ON CODE	SMR CODE
			1	2	3	4	5	6	7			
10-1-15	60-6619-2	81205	.	.	.	WASHER, Nose gear oleo.....				AR		
	60-6619-3	81205	.	.	.	upper, 0.050				AR		
	60-6619-4	81205	.	.	.	WASHER, Nose gear oleo.....				AR		
	60-6619-5	81205	.	.	.	upper, 0.063				AR		
			.	.	.	WASHER, Nose gear oleo.....				AR		
			.	.	.	upper, 0.080				AR		
-16	6-55002-1	81205	.	.	.	WASHER, Nose gear oleo.....				AR		
			.	.	.	upper, 0.090				AR		
	8020062-1	98747	.	.	.	BEARING, Nose gear upper.....				1		PAOZZ
			.	.	.	oleo				1		PAOZZ
			.	.	.	oleo (preferred item)				2		PAOZZ
-17	3-71002-1	81205	.	.	.	KEY, Nose gear upper bearing.....				1		PAOZZ
-18	6-55018-1	81205	.	.	.	WASHER.....				1		PAOZZ
-19	6-55001-1	81205	.	.	.	SPACER, Nose gear upper cam.....				1		PAOZZ
-20	6-68004	81205	.	.	.	CAN, ASSEMBLY, Nose gear.....				REF		
			.	.	.	upper (for replacement, order						
			.	.	.	5 83012-1 and 66-18273)						
	158660	81205	.	.	.	CAN, Nose gear upper (replace.....				REF		
			.	.	.	with 5-83012-1)						
-20A	5-83012-1	81205	.	.	.	CAM, Nose gear upper (use.....				1		PAOZZ
			.	.	.	with 66-18273)						
-20B	66-16273	81205	.	.	.	KEY, Upper cam, nose gear.....				2		PAOZZ
			.	.	.	(use with 5-83012-1)						
-21	43A3MT-160A-N	72902	.	.	.	PACKING ASSEMBLY.....				1		PAOZZ
	43A3MT-2N	72902	.	.	.	BACK-UP RING (optional.....				2		XA
			.	.	.	MS28782-59 use only with						
			.	.	.	AN6227B59)						
	43A2MT-160A	72902	.	.	.	PACKING (optional.....				1		XA
			.	.	.	AN6227B59 use only with						
			.	.	.	MS28782-59)						
-22	Deleted											
-23	66-10461	72902	.	.	.	ADAPTER PACKING.....				1		PAOZZ
-24	42A9FT-160A-N	72902	.	.	.	PACKING ASSEMBLY.....				1		PAOZZ
	42A9FT-2N	72902	.	.	.	BACK-UP RING (optional.....				2		XA
			.	.	.	MS28782-56 use only with						
			.	.	.	AN6227B56)						
	42A9FT-160A	72902	.	.	.	PACKING (optional.....				1		XA
			.	.	.	AN6227B56 use only with						
			.	.	.	MS28782-56)						
-25	Deleted											
-26	69-11344	81205	.	.	.	BEARING LOWER (standard).....				1		PAOZZ
	69-11344-1	81205	.	.	.	BEARING LOWER (oversize).....				1		PAOZZ
-27	MS28932-1	90696	.	.	.	FELT STRIP.....				1		PAOZZ
-28	MS28776M2-45	90696	.	.	.	RING WIPER.....				1		PAOZZ
-29	158665	81205	.	.	.	NUT, Nose gear lower oleo.....				1		PAOZZ
			.	.	.	(optional 9-55612)						
-30	NAS509-16	88044	.	.	.	NUT, Drilled jam.....				1		PAOZZ
-31	3-95613	81205	.	.	.	WASHER, Nose gear drain tube.....				1		PAOZZ
-32	345MS-16A-N	72902	.	.	.	PACKING ASSEMBLY (optional.....				1		PAOZZ
			.	.	.	use AN6227B48 with						
			.	.	.	MS28782-48)						
-33	345MS-2N	72902	.	.	.	RING, Back-up (optional.....				2		PAOZZ
			.	.	.	MS28782-48 use with						
			.	.	.	AN6227B48)						
-34	9-60375	81205	.	.	.	ROD, Orifice, nose gear.....				1		PAODD
-35	6-55020	81205	.	.	.	TUBE, Drain, nose gear.....				1		PAOZZ
-36	AN6227B12	72902	.	.	.	PACKING.....				1		PAOZZ
-37	9-55621	81205	.	.	.	BULKHEAD, Orifice rod, nose.....				1		PAODD
			.	.	.	gear						

10-2 Change 10

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION							UNITS PER ASSY	USABLE ON CODE	SMR CODE
			1	2	3	4	5	6	7			
10-1-38	7531263-10	98747	.	.	.	CYLINDER ASSEMBLY, Nose.....				1		PAODD
						gear inner preferred						
	5-73144	81205	.	.	.	CYLINDER ASSEMBLY, Nose.....				1		XC
						gear inner (replaced by part No.						
						7531263-10)						
	5-73144-1	81205	.	.	.	CYLINDER ASSEMBLY, Nose.....				1		XC
						gear inner welded (replaced						
						by part No. 7531263-10)						
-39	NAS679-A3W	88044	.	.	.	NUT .....				1		PAOZZ
-40	AN960-10	88044	.	.	.	WASHER, Flat .....				1		PAOZZ
-41	AN3H5A	88044	.	.	.	BOLT .....				1		PAOZZ
	65A30315-10	98747	.	.	.	BUSHING .....				AR		PAOZZ
	65A30315-68	98747	.	.	.	BUSHING (use bushing .....				AR		PAOZZ
						part No. 65A30315-10						
						until exhausted)						
-42	90-9128	81205	.	.		CAM ASSEMBLY, Nose gear lower .....				1		PAOZZ
						(optional 90-9128-1)						
	90-9128-2	81205	.	.		CAM ASSEMBLY, Nose gear lower .....				1		PAOZZ
						(optional 90-9128-3)						
	90-9128-3	81205	.	.		CAM ASSEMBLY, Nose gear lower .....				1		PAOZZ
	158662	81205	.	.		CAM, Nose gear lower (optional .....				1		PAOZZ
						5-83011)						
	5-83011-2	81205	.	.		CAM, Nose gear lower .....				1		PAOZZ
	30-3065-1	81205	.	.		KEY .....				2		PAOZZ
-43	5-83025-3	81205	.	.		CYLINDER ASSEMBLY, Outer .....				1		PAODD
						(use 5-83025-4, -5 or -6 until ex-						
						hausted)						

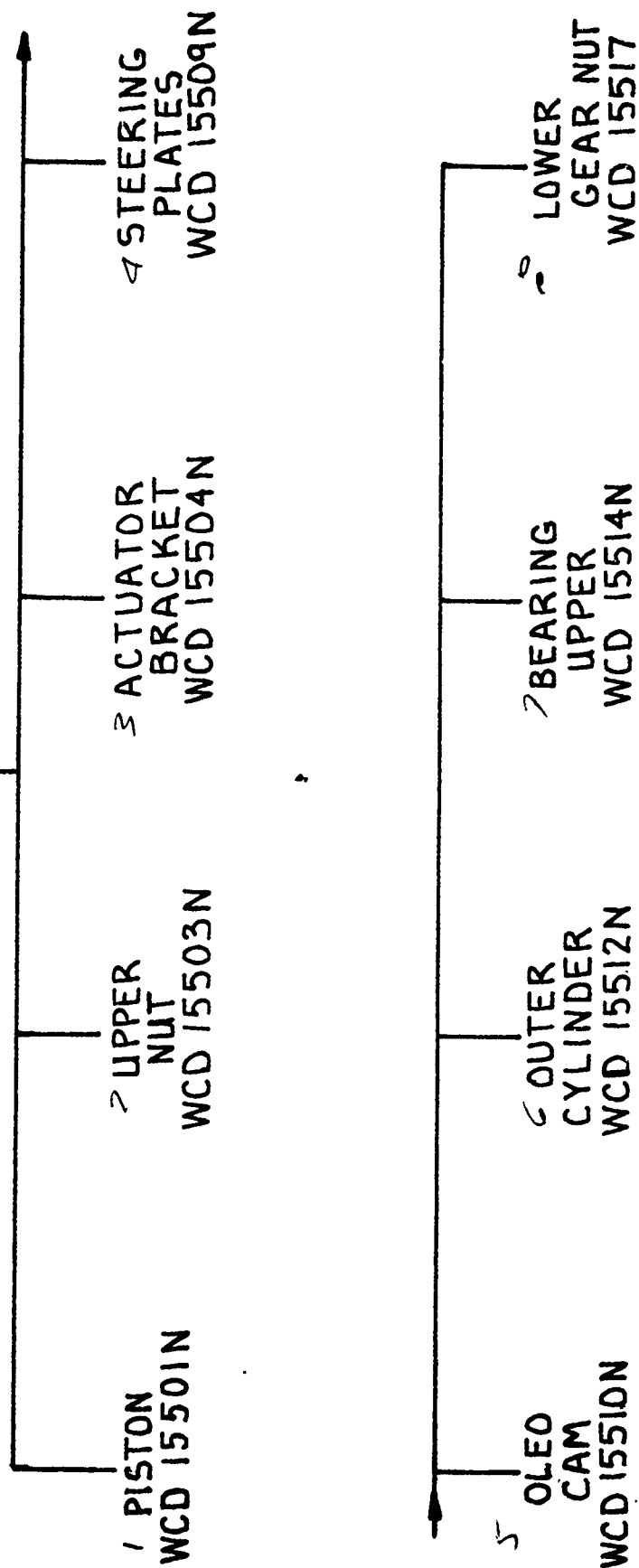
# FAMILY 5

## CONTROL NUMBER LIST

LABO TECH	PLAN TECH	CONTROL NUMBER	JOP DESC	AIRCRAFT	DESCRIPTION	STOCK NUMBER	PART NUMBER	TECHORDER	6019 FLOW DAYS
COOP	TOLM	68878A		F-111 MLG	STRUT ASSY	1620-01-100-9806	7327080-110	4S1-78-3	44
COOP	COOP	68884A	-6	F-15 MLG	STEERING ARM	1620-00-305-1726	68A450653-1001	4A4-22-3	3
COOP	RIGB	68891A	-J	F8-111 MLG	BRAKE BACKING PLATE	1630-00-856-2195	9535519	4B1-2-493	19
MART	SHEL	68973A		F-15	ADU-407	1440-01-064-3475AB	68A731301-1007	11LAB-7-3	7
MART	SHEL	68981A		MULTI	LAUNCHER LAU-101 R/H	1440-01-104-0367AB	7839472-50	11L1-2-11-504	16
DELE		69032A		AE-37A	BATTERY PACK	6135-00-074-2973TA	12 SEPTEMBER 85	802-3-1	
DELE		69072A		LGM-30	BATTERY-POWER	1430-00-135-5627AH	23 DECEMBER 86	8011-3-29-2	
COOP	TOLM	69081A		F-111 MLG	PIN TRUN HINGE	1620-00-118-7445	12L9545-801	4A4-1-113	35
MART	SHEL	69087A		B-52	AMMO BOX	1005-00-970-6111	571541-409	11F8-3-7-3	15
MART	SHEL	69088A		F-16	EXIT UNIT	1005-01-050-2735	16V002002-2	11W1-7-16-2	13
MART	SHEL	69089A		F-15	UNIT ENTRANCE	1005-01-050-2736	16VS002003-2	11W1-7-16-2	9
MART	SHEL	69093A		F-15	UNIT ENTRANCE	1005-00-268-7019	189F490	11W1-7-15-2	7
DELE		69095A			CIRCUIT BOARD MAU-58	1005-00-050-1978	28 OCT 86	11W1-7-10-3	
MART	SHEL	69096A			FEED SYSTEM MAU-58	1005-00-249-9820	7032656	11W1-7-10-3	20
JENS	POLL	69098A	-G-J	C-130	BALLSCREW	1620-00-365-4001	8353-M1	1663-2-01-3	20
COOP	TOLM	69101A		F-111 MLG	BRACE LOWER	1620-00-924-0926	12L9105-1	4A4-15-3	25
DELE		69112A		E-3A MLG	LOWER SIDE STRUT	1620-01-009-0094	30 NOV 87	4S1-106-3	
DELE		69117A		MS-212	AIRFOIL	1325-00-427-9097	23 DEC 86	11A6-12-3	
DELE		69118A		MS-212	AIRFOIL	1325-00-427-9099	23 DEC 86	11A6-12-3	
COOP	POLL	69136A		C-141 MLG	LINK	1620-00-927-2600	3611014-107	4S1-73-3	21
DELE		69216A		F-4	HYD GUN DRIVE	1005-01-041-0667	10 APR 85	11W1-28-5-3	
DELE		69228A		C-130	STAND GUN	1005-00-110-7197	28 OCT 86	11W1-1-34-3-1	
DELE		69247A		F-106 MLG	CENTER LINK BRACE	1620-00-604-7386	19 NOV 86	4S2-40-13	
DELE		69248A		F-111 MLG	PIN STAB ROD	1620-00-422-1832	4 FEB 86	4A4-19-3	
DELE		69271A		F-111 MLG	PIN TRUN HINGE	1620-00-121-9443	4 FEB 86	4A4-1-113	
DELE		69273A		F-111 MLG	PIN STAB ROD	1620-00-221-2453	4 FEB 86	4A4-1-113	
DELE		69276A	-J	F-16 MLG	BRAKE ASSY	1630-01-087-0431	8-12-87	4B1-2-1162	
MART	SHEL	69282A		A-70	HOUSING	1005-00-547-7184	201F315	11W1-7-1-103	20
POLL	POLL	69288A		C-141	BRACE	1620-00-943-0753	3F31004-117	4SA6-19-3	0
DELE		69322A		XM10	FEEDER UNIT SUU-11	1005-00-903-0753	28 OCT 86	11W1-31-3-2	
DELE		69323A		F-15	DRUM ASSY	1005-01-007-7186	28 OCT 86	11W1-7-15-2	
MART	SHEL	69324A	-6	MULTIPLE	MAU-12DA	1005-01-100-3892	69J13060-7	11B29-3-25-2	19
MART	SHEL	69332A		F-4	PYLON O.B. L/H	1560-01-034-5064BF	53673301-25	16N6-1-102	28
BENT	COOP	69354A	-6	KC-135 MLG	STRUT ASSY	1620-01-059-7042	7327075-110	4S2-30-3	37
DELE		69389A		LGM-25	SHOCK STRUT	1450-00-690-6303AE	10 FEB 87	36Y56-2-3	30
DELE		69455A		F-15 MLG	UPPER BRACE	1620-00-305-1772	4 FEB 86	4S2-73-4	
BENT	POLL	69545A		C-130 MLG	STRUT ASSY	1620-00-085-2624	388071-3	4S2-23-3	65
BENT	COOP	69549A		KC-135 MLG	LOWER SIDE SEGMENT	1620-00-138-6373	74-30366-01	4A4-12-23	30
BENT	COOP	69551A		KC-135 MLG	SUPPORT LINK	1620-00-312-9664	5-83050	4A4-12-23	30
BENT	COOP	69554A		KC-135 MLG	UNIVERSAL LOW SIDE STRUT	1620-00-525-1156	9-60346-7	4A4-12-23	25
BENT	COOP	69555A		KC-135 MLG	UPPER UNIVERSAL L/H	1620-00-614-2351	9-60346-7	4A4-12-23	30
BENT	COOP	69556A		KC-135 MLG	ACTUATOR BEAM	1620-00-591-0508	4-30364-10	4A4-12-23	35
BENT	COOP	69557A		KC-135 MLG	BRACE EQUAL ROD	1620-00-650-7900	65-1266-2	4A4-12-23	29
BENT	COOP	69558A	-6	KC-135 MLG	UPPER UNIVERSAL R/H	1620-00-614-2352	9-60346-8	4A4-12-23	30
BENT	POLL	69559A	-6	C-130 MLG	MAIN PISTON	1620-00-862-4057	388059-1	4S1-37-3	63
DELE		69561A		C-130 MLG	AFT TORQUE STRUT	1620-00-862-4059	25 NOV 86	4S1-69-13	
DELE		69562A		C-130 MLG	CYLINDER	1620-00-862-8285	25 NOV 86	4S1-37-3	
BENT	POLL	69563A		C-130 MLG	LOWER TORQUE ARM	1620-00-686-8889	388060-1	4S2-23-3 25	
BENT	POLL	69564A		C-130 MLG	UPPER TORQUE ARM	1620-00-686-8890	388069-1	4S2-23-3	25
BENT	POLL	69567A		C-130 MLG	BRACE ASSY	1620-00-976-3392	371689-7	4SA6-7-3	35



KC-135 NOSE  
LANDING GEAR ASSEMBLY  
PCN 69354A  
WCD 15511N



(G402A-TIP001)

LABOR STD REVIEW 10 APR 89

4:38 PM

PROD		OPER		TYP		STAND		OCC		FACTORED
NBR	RCC	NBR	STD	SK	FAC	HOURS	FAC	HOURS		
69354A	MKPRW	XKPRW	X	4N	6	.54	1.00		54	
FAMILY 5									54	
KC-135	MNPCD	CD514	N	VR	4	.51	1.00		51	
NLG									51	
									5.93	
	MNPGP	00010	N	HB	5	5.93	1.00		5.93	
		PP501	E	3S	5	.34	1.00		34	
		PP512	E	3S	5	.34	1.00		34	
		PS511	N	3S	5	.96	1.00		96	
									7.57	
	MNPGW	PM010	E	DJ	5	1.22	1.00		1.22	
		PM511	E	DJ	5	1.32	1.00		1.32	
		WC001	E	KI	5	1.62	1.00		1.62	
		WD001	E	H3	5	2.50	1.00		2.50	
		WE501	E	DI	5	1.15	1.00		1.15	
		WE503	N	DI	5	.16	1.00		16	
		WE504	N	DI	5	.26	1.00		26	
		WE509	N	DI	5	.26	1.00		26	
		WE510	N	DI	5	.40	1.00		40	
		WE512	E	DI	5	1.16	1.00		1.16	
		WE514	N	DI	5	.28	1.00		28	
		WE517	N	DI	5	1.13	1.00		1.13	
		WE528	N	DI	5	.16	1.00		16	
		XNPGW	X	HB	5	5.69	1.00		5.69	
									17.31	
	MNPNA	NA501	E	DB	2	.94	1.00		94	
		NA503	E	DB	2	.10	.47		4	
		NA504	E	DB	2	.33	1.00		33	
		NA509	E	DB	2	.29	.61		17	
		NA510	E	DB	2	.10	.10		1	
		NA512	E	DB	2	.50	.96		48	
		NA517	E	DB	2	.10	1.00		10	
		NA528	E	DB	2	.10	1.00		10	
		XNPNA	X	DB	2	4.71	1.00		4.71	
									6.88	
	MNPRA	RA501	N	JA	1	1.42	.29		41	
		RA503	E	JA	1	.28	1.00		28	
		RA504	E	JA	1	.79	1.00		79	
		RA509	E	JA	1	1.30	.79		1.09	
		RA510	E	JA	1	.34	.05		4	
		RA511	E	JA	1	.7	1.00		0.75	

(G402A-TIP001)

LABOR STD REVIEW 10 APR 89

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FACTORED

PROJ NBR	ACC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	STAND HOURS
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11.47

09354A	MNPR2	R6501	E	JA	1	5.65	.21	1.18
		R6512	N	JA	3	3.03	.50	1.51

2.69

MNPRC	RC501	N	UP	S		4.27	.53	2.47
	RC503	E	UP	B		.61	.38	23
	RC504	E	UP	B		.69	.46	31
	RC509	E	UP	B		2.09	1.08	2.25
	RC510	E	UP	B		.54	.63	40
	RC512	E	UP	B		1.94	.71	1.37
	RC517	E	UP	B		1.54	.05	8
	RC528	E	UP	B		1.69	2.00	3.38
	XNPRC	X	UP	B		2.55	1.00	2.55

13.04

MNPWW	WF512	N	WF	9		6.19	.22	1.36
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1.36

61.37

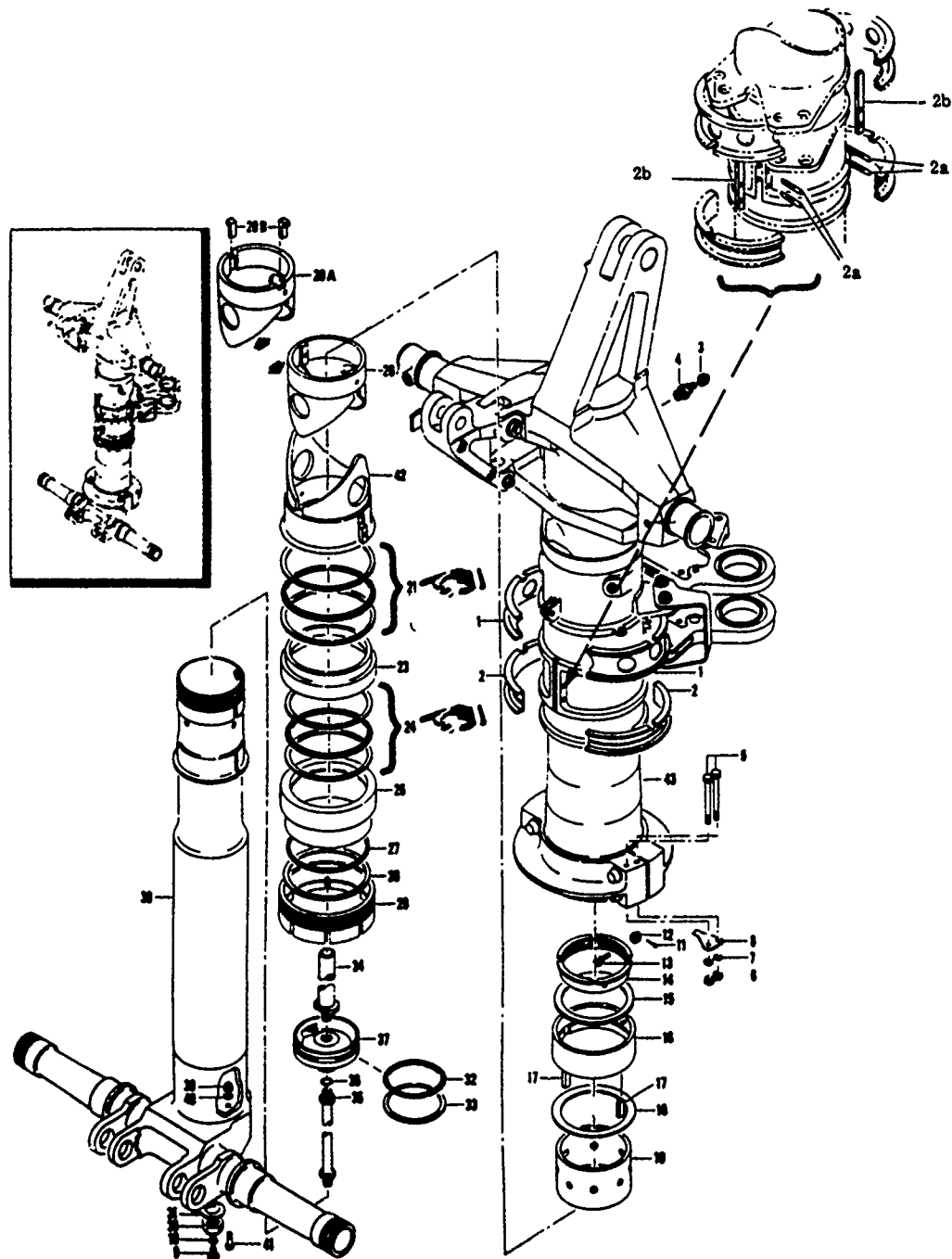


Figure 10-1. Nose Gear Oleo Assemblies

■ 10-4 Change 9

Pages 10-4A and 10-4B are deleted in their entirety.

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
10-2-	5-83025-3	81205	CYLINDER ASSEMBLY, NOSE GEAR.....	REF		PAODD
	5-83025-4	81205	OUTER CYLINDER ASSEMBLY, NOSE GEAR.....	REF		PAODD
	5-83025-5	81205	OUTER CYLINDER ASSEMBLY, NOSE GEAR.....	REF		PAODD
	5-83025-6	81205	OUTER CYLINDER ASSEMBLY, NOSE GEAR.....	REF		PAODD
	7327022-30	98747	OUTER CYLINDER ASSEMBLY, NOSE GEAR.....			PAODD
-1	NAS1022-A9	88044	NUT.....	8		PAOZZ
	MS21245-L9	88044	NUT.....	8		PAOZZ
-2	AN960D916	88044	WASHER.....	4		PAOZZ
-3	3-95685	81205	PIN, Steering plate, nose gear.....	8		PAOZZ
-4	60-6144	81205	BRACKET, Wire support, nose gear.....	1		PAOZZ
-5	KP498	80205	BEARING, Ball, ar frame.....	4		PAOZZ
-6	5-73193	81205	PLATE, Support, steering cylinder.....	1		PAODD
	NAS537B12P-21	88044	nose gear BUSHING (Repair only).....	AR		PAOZZ
-7	5-73193-1	81205	PLATE, Support, steering cylinder.....	1		PAODD
	NAS537B12P-21	88044	nose gear BUSHING (Repair only).....	AR		PAOZZ
-8	NAS1022-A9	88044	NUT.....	1		PAOZZ
-9	NAS1022-A10	88044	NUT.....	1		PAOZZ
-10	AN960D916	88044	WASHER.....	1		PAOZZ
-11	AN960D1016	88044	WASHER.....	1		PAOZZ
-12	NAS1109-44W	88044	BOLT, Shear, close tolerance.....	1		PAOZZ
-13	MS20002C9	88044	WASHER, Countersunk.....	1		PAOZZ
-14	NAS1110-58W	88044	BOLT, Shear, close tolerance.....	1		PAOZZ
-15	MS20002C10	88044	WASHER, Countersunk.....	1		PAOZZ
-16	5-72349	81205	BRACKET, Actuator attaching, nose gear (optional 5-72439-200)	1		PAOZZ
-17	AN380-3-3	88044	PIN, Cotter.....	1		PAOZZ
-18	AN310-6	88044	NUT.....	1		PAOZZ
-19	NAS1306-118DH	88044	BOLT, Shear.....	1		PAOZZ
-20	AN6246-56	88044	GASKET.....	1		PAOZZ
	MS28774-429	88044	RETAINER, Packing, back-up (optional MS28782-56)	1		PAOZZ
-21	AN6227-56	88044	PACKING.....	1		PAOZZ
-22	6-55019	81205	RING PISTON.....	1		PAODD
	5-83018	81205	TUBE ASSEMBLY, Piston nose gear.....	1		PAODD
-23	52-040-187-0562	72962	PIN, Spring (BAC-P18L-12P.....	1		PAODD
			0562)			
-24	6-68072	81205	PLATE, Orifice, nose gear piston.....	1		PAODD
			tube			
-25	5-83018-1	81205	TUBE, Piston, nose gear.....	1		PAODD
	6-14297		TUBE ASSEMBLY, Piston, nose gear.....	1		PAODD
-26	NAS561PF6-12		PIN, Spring.....	1		PAODD
-27	6-68072		PLATE, Orifice.....	1		PAODD
-28	65-14297-1		TUBE, Piston, nose gear.....	1		PAODD
-29	6-68015		LOCKSCREW, Nose gear trunnion.....	3		PAOZZ
	8121566-05	98747	LOCKSCREW, Nose Gear trunnion.....	3		PAOZZ
			(oversize) (can be used in place of 6-68015)			
	8121566-21	98747	LOCKSCREW, Nose gear trunnion.....	3		PAOZZ
			(oversize)			
	68J29645-61-S32P		BUSHING, (repair only) cylinder.....	AR		PAODD
			trunnion retaining pin hole			
-30	NAS1022C10		NUT.....	1		PAOZZ
-31	6-68015-1		LOCKSCREW, Nose gear trunnion.....	1		PAOZZ
	8121566-01	98747	LOCKSCREW, Nose gear trunnion.....	1		PAOZZ
			(can be used in place of 6-68015-1)			
	8121566-07	98747	LOCKSCREW, Nose gear trunnion.....	1		PAOZZ
			(oversize)			
	8121566-15	98747	LOCKSCREW, Nose gear trunnion.....	1		PAOZZ
			(oversize)			
	65832580-05		BUSHING (repair only).....	AR		FAODD

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
10-2-32	6-68002 7729421-03		TRUNNION, Nose gear .....	1		PAOZZ
			TRUNNION, Nose Gear (replaces part Nos. 6-68002, 6-68001, and 7729421-01)	2		PAODD
-33	MS24665-370		KEY, Cotter .....	1		
	MS24665-377		KEY, Cotter .....	1		
-34	3-71050		WASHER, Nose gear swivel fitting .....	1		PAOZZ
-35	6-55067		FITTING, Swivel, nose gear .....	1		PAOZZ
-36	AN6246-23		GASKET .....	6		PAOZZ
	MS28774-218		RETAINER, Packing back-up (optional.... MS28782-23)	6		PAOZZ
-37	AN6227B23		PACKING .....	3		PAOZZ
	MS28775-218		PACKING (Alternate to part No. .... AN6227B23)	3		PAOZZ
-38	52-028-125-2000		PIN, Spring .....	1		PAOZZ
	9-55602		SWIVEL ASSEMBLY, Steering, nose .....	1		PAOZZ
			gear (for replacement use 7729422-30)			
-39	AN913-15		PLUG, Pipe .....	2		
-40	9-55602-1		SWIVEL FITTING, Steering, nose .....	1		PAOZZ
			gear			
	9-55602-2		SWIVEL ASSEMBLY, Steering nose .....	1		PAOZZ
			gear (for replacement use 7729422-30)			
-40a	3A		PLUG, Pin .....	2		PAOZZ
-40b	9-55602-3		SWIVEL FITTING, Steering, nose .....	1		PAOZZ
			gear			
	65832580-05		BUSHING (repair only) .....	AR		PAODD
	7729422-30		SWIVEL ASSEMBLY, Steering nose .....	2		XA
			gear (when 9-55602 and 9-55602-2 are beyond repair, this assembly will be used) (use with trunnion pin 7729421-03)			
	7729421-03		SWIVEL FITTING .....	1		PAOZZ
	281101	92555	PLUG .....	2		XA
-41	6-68001		TRUNNION, Nose gear .....	REF		
	7729421-03		TRUNNION (preferred item) .....	1		PAOZZ
-42	AN3H4A		BOLT .....	1		PAOZZ
-43	6-68014		BRACKET, Steering shutoff valve .....	1		PAOZZ
			actuator			
	6-68014-1		BRACKET, Steering shutoff valve .....	1		PAOZZ
			actuator			
-44	1191-3CX.380		SLEEVE, Steel wire .....	1		PAOZZ
	BAC-S13P-3C-4		SLEEVE, Steel wire .....	1		PAOZZ
	MS124735		SLEEVE, Steel wire (alternate to..... 1191-3CX.380 and BAC-S13P-3C- 4)	1		PAOZZ
-45	AN6227-11		PACKING .....	1		PAOZZ
-46	3-71015		FITTING, Nose gear air valve .....	1		PAOZZ
-47	RZA-10330-7		RING, Lock .....	4		PAOZZ
-48	R206S88		SLEEVE, Threaded .....	4		PAOZZ
-49	BAC-M10L-33-1BED		METAL-CAL .....	1		PAOZZ
-50	BAC-M10L-31-1AUR		METAL-CAL .....	1		PAOZZ
-51	BAC-M10L-32-1BEG		METAL-CAL .....	1		PAOZZ
	65-13211-3		CLAMP ASSEMBLY, Nose gear outer .....	1		PAODD
			cylinder			
-52	NAS1021A8		NUT .....	4		PAOZZ
-53	AN960PD816		WASHER .....	4		PAOZZ
-54	MS20008-46		BOLT .....	4		PAOZZ
-55	MS20002-C8		WASHER, Countersunk .....	4		PAOZZ
-56	65-13211-4		CLAMP HALF .....	1		PAODD
-57	65-13211-5		CLAMP HALF .....	1		PAODD

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION							UNITS PER ASSY	USABLE ON CODE	SMR CODE
			1	2	3	4	5	6	7			
10-2-58	MS29513-260		.							2		PAOZZ
	65-4854-5		.							1		PAODD
	65-4854-3001		.							1		PAODD
	7327022-30		.							1		PAODD
	5-83005-8		.							1		PAODD
	5-83005-9		.							1		PAODD
	65-4854-4		.							1		PAODD
	65-4854-2002		.							1		PAODD
.59	7327021-03		.							1		XA
.60	MS15001-1		.							2		PAOZZ
.61	63-2030-1		.							2		PAOZZ
.62	SS-48165		.							2		PAOZZ
.63	63-2030-2		.							2		PAOZZ
.64	MS15001-1		.							2		PAOZZ

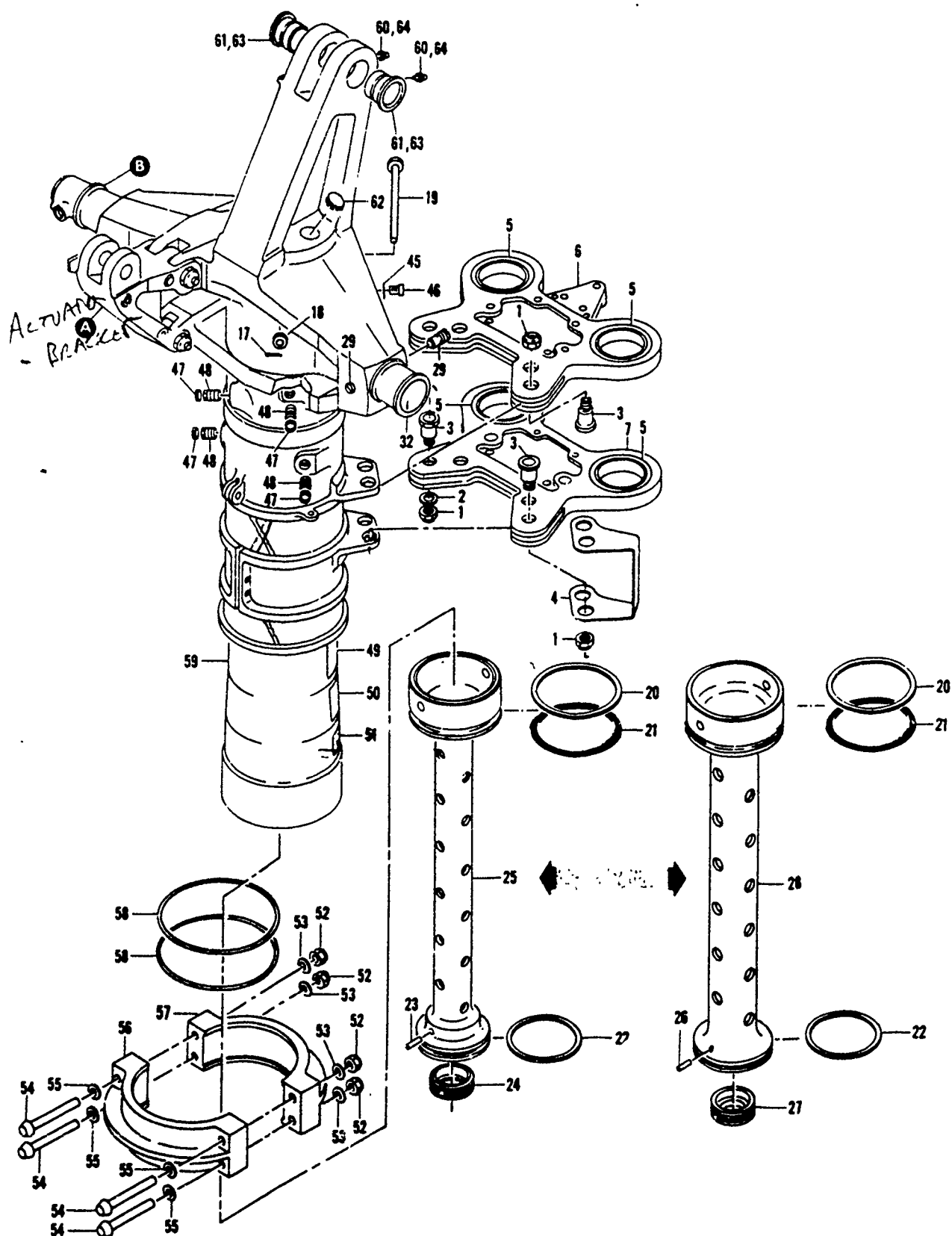


Figure 10-2. Nose Gear Outer Cylinder Assemblies (Sheet 1 of 2)



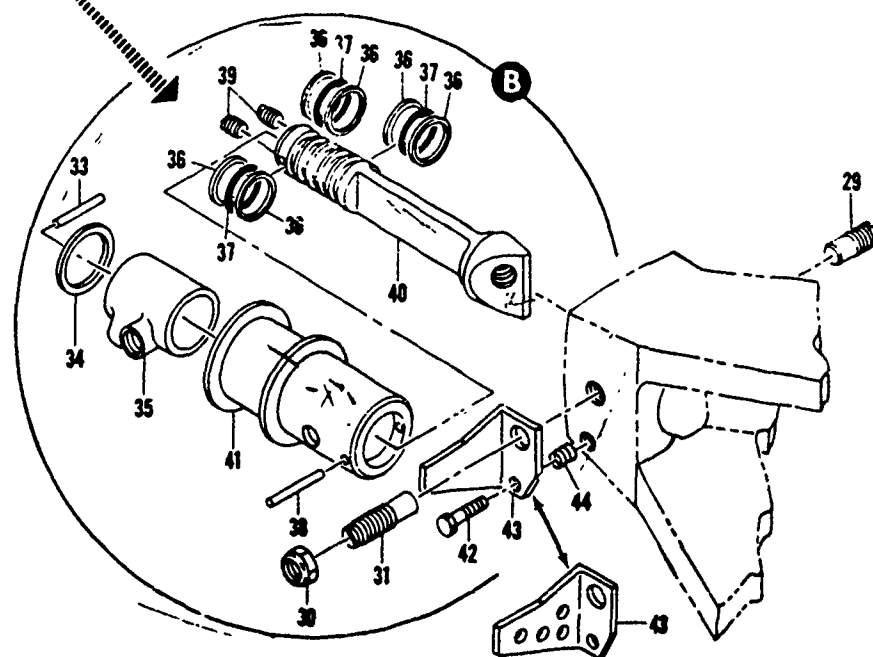
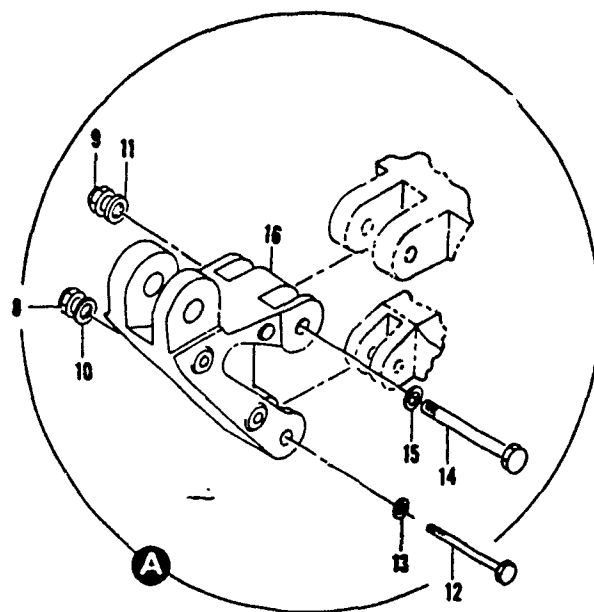
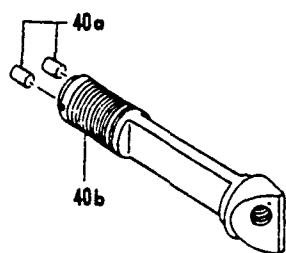
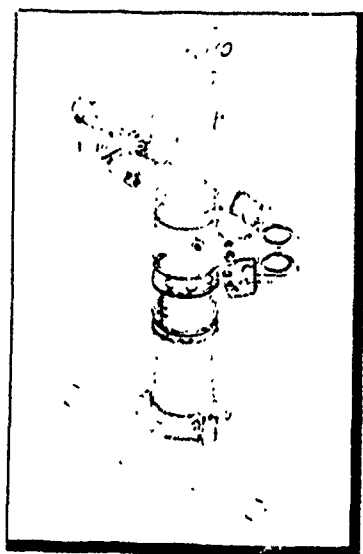


Figure 10-2. Nose Gear Outer Cylinder Assemblies (Sheet 2 of 2)

## Bill of Materials

**Case 1:13-cv-00001-UNA Document 1-1 Filed 07/25/13 Page 1 of 1**

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[illegible]

## STABILITY OF MATERIALS

69734A

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[illegible]

## STUDIES OF MATERIALS

49754A

一、

[illegible]

325

KC-135 NOSE STRUT ASSEMBLY

BILL OF MATERIALS

69354A

五  
十  
五

87L-STEEL  
AL-ALUMINUM  
MAG-MAGNESIUM  
TITA-TITANIUM  
88-8 87L  
89-8 87L  
90-8 87L

ROUTED	ITEM	ITEM LEVEL	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER 1 OF PART	YIELD LOSS	DATE	CONTROL	REV	TECH	NO	PENDING ACTION	PENDING ACTION	PENDING ACTION
	1.1	108124735		IN.S.L.		1. SLEEVE STEEL WIRE	11	1EA								
	1.1	108127-11		15330001873435	180044	1. PACKING, O-RING	11	1EA								
	1.1	15-71015		11620007049732	181205	1. FITTING, AIR VALVE	11	1EA								
STL	1.1	102A-10330-7		15365004825877	183324	1. RING, LOCK	14	1EA								
	1.1	102A488		15340002905090	183324	1. INSERT	14	1EA								
AL	1.1	165-13211-3		11620007871752	181205	1. CLAMP ASBY	11	1EA								
	1.2	1081102118		15310005829435	180205	1. NUT, SELF LOCK	14	1EA								
	1.2	1081602016		15310001670751	180044	1. WASHER	14	1EA								
	1.2	108200108-46		15304011564395	196775	1. BOLT	14	1EA								
	1.2	108200102-28		15310001499116	196906	1. WASHER, COUNTERSINK	14	1EA								
AL	1.2	165-13211-4		IN.S.L.	181205	1. CLAMP	11	1EA								
AL	1.2	165-13211-5		IN.S.L.	181205	1. CLAMP	11	1EA								
	1.1	108200135-260		15330002526441	196906	1. PACKING	12	1EA								
	1.2	1081301-1		1732000504205	196906	1. FITTING, LUB	12	1EA								
	1.2	158-48165		15340001049617	180058	1. PLUS, BUTTON	12	1EA								
	1.2	17327021-03		IN.S.L.		1. OUTER CYL. SUBMISSY	11	1EA								
	1.3	163-2030-1		13120007874100LE	181205	1. BUSHING, DRAG BRACE HOLE	12	1EA								
	1.3	163-2030-2		1312000793735ALE	181205	1. BUSHING, DRAG BRACE HOLE (O.S.)	12	1EA								
	1.3	163-2030-3		13120009412913LE	196747	1. BUSHING, TRUNION HOLE (O.S.) (RPR)	12	1EA								
	1.3	163-2030-01		131200010448572	196747	1. BUSHING, TRUNION HOLE (O.S.) (RPR)	12	1EA								
	1.3	163-2030-03		13120001940264LE	196747	1. BUSHING, TRUNION HOLE (O.S.) (RPR)	12	1EA								
	1.3	163-2030-45-61-5329		13120001319211	180205	1. BUSHING, STEERING LUGS (O.S.) (RPR)	18	1EA								
	1.3	108537812P-43		13120001319213	180205	1. BUSHING, ACTUATOR HOLE (O.S.) (RPR)	12	1EA								
	1.3	108537810P-86		13120001319210	180205	1. BUSHING, ACTUATOR HOLE (O.S.) (RPR)	12	1EA								
	1.3	108537810P-61		13120001319210	180205	1. BUSHING, ACTUATOR HOLE (O.S.) (RPR)	12	1EA								
	1.3	163A30315-11A		131200009433285	196747	1. BUSHING, DR ATTUB (4130 STL)	12	1EA								
	1.3	163A30315-11B		131200009433285	196747	1. BUSHING, DR ATTUB (4130 STL)	12	1EA								
	1.3	17327022		IN.S.L.		1. OUTER CYL. (MACHINED)	11	1EA								
	1.1	108C-H10L-33-10ED		IN.S.L.		1. DECAL	11	1EA								
	1.1	108C-H10L-31-10UR		IN.S.L.		1. DECAL	11	1EA								
	1.1	108C-H10L-33-10EB		IN.S.L.		1. DECAL	11	1EA								
	1.1	108P017-A		153340000841743	181349	1. PLUS, PROTECTIVE	14	1EA								

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15511N

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC MNPGR		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA 4S-1-182 4S2-30-3				9. ITEM SERIAL NO.	
10. MODEL DESIGN SERIES KC135 NOSE				11. STOCK NUMBER				12. OPTIONAL	
13. SERIAL NUMBER				14. NOUN STRUT ASSY (NOSE)					
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
7327025-50	1620010381912	17567A							
7327025-110	1620010597842	69354A							
		GOVERNING DIRECTIVES: AFLCP 66-51 MANOI 66-3 *****7049 ALUMINUM*****							
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.							
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		WARNING							
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/EN			
DISPATCH	FUNCTIONAL CODE	A		C		15511N			
		B		D					

\* U.S. GOVERNMENT PRINTING OFFICE: 1988-548-185

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1 DATE 89038

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STRUT ASSY (NOSE)						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
	001	7327025-50 7327025-110							
34A	010	MATCH UP ****ROUTED COMPONENTS**** NEW/ REWORKED NO SERVICABLE 958 REWORK					M	MNDGP 06 MU01	
		PISTON 15501N NUT UPPER OLEO 15503N ACTUATOR BRACKET 15504N STEERING PLATES 15509N OLEO CAM UPPER & LOWER 15510N OUTER CYL 15512N BEARING UPPER 15514N LOWER GEAR NUT 15517							
34A	020	OK TO CLOSE AND/OR ASSEMBLE *C/P MOVE					M	MNDGP 06 SA03	
34A	030	ASSEMBLE INTERNAL PARTS *C/P MOVE NEW OUTER S/N NEW INNER S/N					M	MNDGP 06 SA03	
34A	040	INSTALL SWIVEL ASSY P/N 9-55602-1 INSTALL SWIVEL FITTING P/N 6-55067 CAUTION: SWIVEL MUST NOT BE (CONTINUED)					M	MNDGP 06 SA03	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A				15511N			
		B				32A			

32A

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1 DATE 89038

3 3

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STRUT ASSY (NOSE)						
18. DISPATCH STATION	19. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. P	20. Q	
		INSTALLED UPSIDE DOWN *C/P MOVE							
34A	050	CAM ALIGNMENT *C/P MOVE *REQD					M	MNPGP 06 SA03	
34A	055	TORQUE ALL NUTS & BOLTS IAW T O *C/P MOVE *REQD					M	MNPGP 06 SA03	
34T	060	PRESSURE TEST *C/P MOVE *REQD					M	MNPGP 06 TL07	
34P	080	MASK, PRIME, AND PAINT *C/P MOVE *REQD					M	MNPGP 09 WB03	
34P	090	DECALS *C/P MOVE *REQD					M	MNPGP 09 WB03	
34P	105	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD OF ALL PRECEDING OPERATIONS THIS 958					M	MNPGP 09 WB03	
34P	120	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD					M	MNPGP 09 WB03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	15511N
		B	D	



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1 DATE

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
		MNP GP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	46-1-182	

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
KC135 NOSE		17567A
13. SERIAL NUMBER	14. NOUN	
	PISTON	69354A

15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
7531263-10		1620010284057 17567A 69354A			
		GOVERNING DIRECTIVE: APL M A-51			
		ALODINE IAW MIL-C-5541			
		IVE ALUM PLATE IAW MIL-C-5541			
		BLAST IAW MIL-STD-1504			
		FPI IAW MIL-STD-883C			
		FAPL IAW MIL-STD-193			
		GRIND IAW MIL-STD-883C			
		TEMP & ELEM IAW MIL-STD-883C			
		SHOT PRES IAW MIL-STD-883C			
		CHROME IAW MIL-STD-883C			
		QAD PLATE IAW MIL-STD-883C			
		STRIP IAW MIL-STD-883C			
		BAKE IAW 46-1-182			
		PERMATEL STEEL (220/300 PSI)***			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (O/P SOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING			
		MANY OF THE FOLLOWING REPAIR			

21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/BN
DISPATCH		15501N
FUNCTIONAL CODE		

FORM 888M 688 MAY 80

PREVIOUS EDITION WILL BE USED

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL DESIGN SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NGUN PISTON						
15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	7531263-10							
	005	DISASSEMBLE *C/P MOVE *REQD* REMOVE & SERIALIZE SHOULDER BLOCKS WITH PISTON SERIAL # AND LOG NO.					001 MRF GW 002 02 003 1002 004 003 00200 006 003 00100		
	007	CHEM CLEAN *C/P MOVE *REQD*					001 MRF GW 002 03 003 SLO1		
	009	BLAST CLEAN ONLY *C/P MOVE *REQD*					001 MRF GW 002 03 003 BL01		
	011	BAKE 4 HRS AT 350-400F *REQD* DATE IN _____ TIME IN _____					001 MRF GW 002 02 003 BK03		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
21. FINAL DESTINATION DISPATCH		22. COORDINATION/INITIATING RCC SIGNATURE/DATE A		23. DOCUMENT/EN 15501N					

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.		

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN PISTON	

15. DISPATCH STATION	16. PERP. REC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE	M	001 MNRNA 002 05 003 CL04	
	*REQD*				
	020	E & I INSPECTION		001 MNRNA 002 01 003 EL01	
	*REQD*	INNER CYL OD 4.999/5.001			
		AXLE JOURNAL INBOARD OD 2.9988/2.9998			
		AXLE JOURNAL OUTBOARD OD 2.4993/2.4998			
		TORQUE ARM BOSS HOLES ID 1.501/1.502 1.375/1.380 FACE TO FACE			
		UPPER BEARING LAND OD 4.750/4.752			
		NOTE: IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL FMPI MUST BE PERFORMED.			
		*C/P MOVE			
26	035	VAPOR DEGREASE	*C/P MOVE	001 MNRRC 002 03 003 DG01	
26	040	STRIP CAD	*C/P MOVE	001 MNRRC 002 02 003 LS01	
26	045	STRIP RUST	*C/P MOVE	001 MNRRC 002 02 003 CS02	
		2 IN. RADIUS *C/P MOVE		001 MNRRA 002 04 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL	A	B	15501N

15501N WORK CONTROL DOCUMENT (MEDS)				1 DATE	PAGE 4 OF 4 PAGES	
2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/REC	5 DATE SCHED.	6 DATE COMPLETED		
7 PART NUMBER		8 TECH DATA		9 ITEM SERIAL NO.		
10 MODEL DESIGN SERIES		11 STOCK NUMBER		12 OPTIONAL		
13 SERIAL NUMBER		14 NGUN				
		PISTON				
15 DISPATCH STATION	16 PERF REC/OP NO.	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"	
26	080	TORQUE ARM BOSS OVERSIZE REPAIR OVERSIZE BY REAMING OR HONING ONLY OVERSIZE TO CLEANUP WITHIN ID 1.5827/1.780 NOTE: DO NOT EXCEED MIN WALL OF .320 *C/P MOVE		001 MNFRA 002 04 003 BE01		
26	070	STRIP CHROME FROM PISTON *C/P MOVE		001 MNFRC 002 02 003 SC02		
26	080	STRIP CHROME FROM AXLE JOURNAL #1 (OUTBOARD) VIEWED UPRIGHT FACING TORQUE ARM LUGS #LEFT TO RIGHT 1-4 *C/P MOVE		001 MNFRC 002 02 003 SC02		
26	090	STRIP CHROME FROM AXLE JOURNAL #1 (INBOARD) VIEWED UPRIGHT FACING TORQUE ARM LUGS #LEFT TO RIGHT 1-4 *C/P MOVE		001 MNFRC 002 02 003 SC02		
26	100	STRIP CHROME FROM AXLE JOURNAL #3 (INBOARD) VIEWED UPRIGHT FACING TORQUE ARM LUGS #LEFT TO RIGHT 1-4 *C/P MOVE		001 MNFRC 002 02 003 SC02		
26	110	STRIP CHROME FROM AXLE JOURNAL #4 (OUTBOARD) VIEWED UPRIGHT FACING TORQUE ARM LUGS #LEFT TO RIGHT 1-4 *C/P MOVE		001 MNFRC 002 02 003 SC02		
26	120	STRIP CHROME FROM UPPER BEARING AREA *C/P MOVE		001 MNFRC 002 02 003 SC02		
26	130	TURIND INNER CYL MIN OD 4.981 *C/P MOVE		001 MNFRC 002 03 003 GG01		
26	140	TURIND STEEL UPRIGHT FACING TORQUE ARM LUGS #LEFT TO RIGHT 1-4 *C/P MOVE		001 MNFRC 002 03 003 GG01		
21 FINAL DESTINATION		22 COORDINATION/INITIATING RES SIGNATURE/DATE		23 DOCUMENT/BN		
15501N				15501N		

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
----------------	--------------	--------------------

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NAME PISTON	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
----------------------	---------------------	-----------------------------	--------------	---------	---------

		*C/P MOVE			
--	--	-----------	--	--	--

86 J	150	GRIND AXLE JOURNAL #2 MIN OD 2.9838 (INBOARD) VIEWED UPRIGHT FACEING TORQUE ARM LUGS #LEFT TO RIGHT 1-4		001 MNFRB 002 03 003 G601	
------	-----	---	--	---------------------------------	--

86 J	160	*C/P MOVE GRIND AXLE JOURNAL #3 MIN OD 2.9838 (INBOARD) VIEWED UPRIGHT FACEING TORQUE ARM LUGS #LEFT TO RIGHT 1-4		001 MNFRB 002 03 003 G601	
------	-----	--	--	---------------------------------	--

86 J	170	*C/P MOVE GRIND AXLE JOURNAL #4 MIN OD 2.4843 (OUTBOARD) VIEWED UPRIGHT FACEING TORQUE ARM LUGS #LEFT TO RIGHT 1-4		001 MNFRB 002 03 003 G601	
------	-----	---	--	---------------------------------	--

86 J	180	*C/P MOVE GRIND UPPER BEARING LAND MIN DIA 4.740		001 MNFRB 002 03 003 G601	
------	-----	--	--	---------------------------------	--

		TIME OUT _____ DATE OUT _____	M	001 MNFRB 002 06 003 TE:3	
--	--	-------------------------------	---	---------------------------------	--

		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *			
--	--	--	--	--	--

268	200	BAKE 4 HRS AT 350-400F WITHIN 8 HRS OF ETCH		001 MNFRB 002 02 003 BK01	
-----	-----	--	--	---------------------------------	--

		DATE IN _____ TIME IN _____			
		DATE OUT _____ TIME OUT _____			

		MOVE *C/P MOVE ***** NOTE *****	M	001 MNFRB 002 06 003 ML04	
--	--	---------------------------------------	---	---------------------------------	--

21. FINAL DESTINATION	22. COORDINATION/INITIATING REQ SIGNATURE/DATE	23. DOCUMENT/ON
		15501N

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1 DATE 89038 PAGE 4 OF 4 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO.

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL N. USER	14. NOUN PISTON	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		IF LAST NOI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *****			
26	225	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 1001	
26	230	SHOT PEEN O.D. SHOT SIZE .019/.028 INTENSITY OF .008/.012 A2 100% COVERAGE *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	240	SHOT PEEN AXLE I.D. INTENSITY OF .010/.014A 200% COVERAGE *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	250	SHOT PEEN REWORKED AXLE JOURNALS SHOT SIZE .019/.028 INTENSITY .008/ 012 A2 100% COVERAGE *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	260	SHOT PEEN UPPER BEARING AREA INTENSITY OF .008/.010A 100% COVERAGE *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	265	PREPARE INNER CYLINDER I.D. FOR CHROME PLATE, MASK/FIXTURE, ETC.  MECHANIC SIGN OFF REQUIRED *C/P MOVE		001 MNPRC 002 02 003 BE01	
26	267	PREPARE UPPER BEARING AREA O.D. FOR CHROME PLATE, MASK/FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED *C/P MOVE		001 MNPRC 002 02 003 BE01	
26	270	CHROME PLATE INNER CYLINDER O.D. SUFFICIENT TO ALLOW GRINDING BACK TO 4.999/5.001 TYPE II CLASS II		001 MNPRC 002 02 003 CP01 008 50010	

21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/BN
		15501N

15501N

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

89038

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
7. PART NUMBER	8. TECH DATA			9. ITEM SERIAL NO.

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN PISTON	

16. DISPATCH STATION	18. PERP. RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		TIME OUT _____ DATE OUT _____ MECHANIC SIGNOFF REQUIRED-----> *C/P MOVE			
26	275	CHROME PLATE UPPER BEARING AREA O.D. TYPE II CLASS II TO ALLOW GRINDING BACK TO 4.750/4.752.		001 MNRC 002 02 003 5401	
		TIME OUT _____ DATE OUT _____ MECHANIC SIGNOFF REQUIRED-----> *C/P MOVE		008 02-20	
26B	280	BAKE 4 HRS AT 350-400F WITHIN 4 HRS OF CHROME		001 MNRC 002 02 003 BK01	
		DATE IN _____ TIME IN _____  DATE OUT _____ TIME OUT _____			
26	285	*C/P MOVE PREPARE JOURNALS FOR CHROME PLATE. FIXTURE/MASK/ETC. MECHANIC SIGN OFF REQUIRED-----		001 MNRC 002 02 003 BE01	
26	290	CHROME PLATE AXLE JOURNAL #1 VIEWED UPRIGHT FACING TORQUE ARM LUGS # LEFT TO RIGHT 1-4 TYPE II CLASS II SUFFICIENT TO GRIND BACK TO 2.4993/2.4998.		001 MNRC 002 02 003 CP01	
		TIME OUT _____ DATE OUT _____ MECHANIC SIGNOFF REQUIRED-----		008 00-00	
26	300	*C/P MOVE CHROME PLATE AXLE JOURNAL #2 VIEWED UPRIGHT FACING TORQUE ARM LUGS # LEFT TO RIGHT 1-4 TYPE II CLASS II SUFFICIENT TO GRIND BACK TO 2.9988/2.9998.		001 MNRC 002 02 003 CP01	
		TIME OUT _____ DATE OUT _____ MECHANIC SIGNOFF REQUIRED-----		008 00-40	

31. FINAL DESTINATION		32. COORDINATION/INITIATING RCC SIGNATURE/DATE		33. DOCUMENT/BN
DISPATCH	FUNCTIONAL	A	B	15501N

15501N

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCG	5. DATE SCHED.	6. DATE COMPLETED
7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO.

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. ROOM PISTON	

18. DISPATCH STATION	19. PERP RCG/OP NO.	17. WORK TO BE ACCOMPLISHED	16. MECHANIC	15. "P"	14. "Q"
		*C/P MOVE			
26	320	CHROME PLATE AXLE JOURNAL #3 VIEWED UPRIGHT FACING TORQUE ARM LUGS # LEFT TO RIGHT 1-4 TYPE II CLASS II SUFFICIENT TO GRIND BACK TO 2.9988/2.9998. TIME OUT _____ DATE OUT _____ MECHANIC SIGNOFF REQUIRED		001 MNFR 002 02 003 CPG1	
		*C/P MOVE			
26	342	CHROME PLATE AXLE JOURNAL #4 VIEWED UPRIGHT FACING TORQUE ARM LUGS # LEFT TO RIGHT 1-4 TYPE II CLASS II SUFFICIENT TO GRIND BACK TO 2.4993/2.4998. TIME OUT _____ DATE OUT _____ MECHANIC SIGNOFF REQUIRED		001 MNFR 002 02 003 CPG1	
		*C/P MOVE			
26	345	BAKE 4 HRS AT 350-400 F WITHIN 4 HRS OF CHROME PLATE. TIME IN _____ DATE IN _____ TIME OUT _____ DATE OUT _____ *C/P MOVE		001 MNFR 002 02 003 BKO1	
		*C/P MOVE			
80	370	FINISH GRIND UPPER BEARING AREA O.D. 4.750/4.752 *C/P MOVE		001 MNFR 002 03 003 GGO1	
80	380	FINISH GRIND INNER CYLINDER O.D. 4.999/5.001 *C/P MOVE		001 MNFR 002 03 003 GGO1	
		FINISH GRIND INNER CYLINDER O.D. 4.999/5.001 VIEWED UPRIGHT FACING TORQUE ARM LUGS LEFT TO RIGHT 1-4		001 MNFR 002 03 003 GGO1	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCG SIGNATURE/DATE		23. DOCUMENT/BN
24. DISPATCH	25. FUNCTIONAL			15501N



15501N WORK CONTROL DOCUMENT (MEDS)				1. DATE 8-9028		PAGE 0 OF 0 PAGES	
2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.	
6. PART NUMBER		7. TECH DATA				8. ITEM SERIAL NO.	
10. MODEL DESIGN SERIES		11. STOCK NUMBER		12. OPTIONAL			
13. SERIAL NUMBER		14. NOUN PISTON					
15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED			18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE					
8G	400	FINISH GRIND AXLE JOURNAL #2 O.D. 2.9988/2.9998 VIEWED UPRIGHT FACING TORQUE ARM LUGS LEFT TO RIGHT 1-4				001 MNRB 002 03 003 001	
8G	410	*C/P MOVE FINISH GRIND AXLE JOURNAL #3 O.D. 2.9998/2.9998 VIEWED UPRIGHT FACING TORQUE ARM LUGS LEFT TO RIGHT 1-4				001 MNRB 002 03 003 001	
8G	420	*C/P MOVE FINISH GRIND AXLE JOURNAL #4 O.D. 2.4993/2.4998 VIEWED UPRIGHT FACING TORQUE ARM LUGS LEFT TO RIGHT 1-4				001 MNRB 002 03 003 001	
26B	430	*C/P MOVE BAKE 4 HRS AT 350-400F  DATE IN _____ TIME IN _____				001 MNRB 002 02 003 801	
		DATE CUT _____ TIME CUT _____ *C/P MOVE					
		*C/P MOVE			M	001 MNRB 002 06 003 MLC4	
26	440	VAPOR DEGREASE *C/P MOVE				001 MNRB 002 03 003 D601	
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *****			M	001 MNRB 002 06 003 ZS01	
21. FINAL DESTINATION DISPATCH FUNCTIONAL CODE		22. COORDINATION/INITIATING RCC SIGNATURE/DATE			23. DOCUMENT/EN		
					15501N		

15501N WORK CONTROL DOCUMENT (MEDS)				1. DATE	PAGE 1 OF 1 PAGES
2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCG	5. DATE SCHED.	6. DATE COMPLETED	
7. PART NUMBER		8. TECH DATA	9. ITEM SERIAL NO.		
10. MODEL DESIGN SERIES		11. STOCK NUMBER	12. OPTIONAL		
13. SERIAL NUMBER		14. NAME			
		PISTON			
15. DISPATCH STATION	16. PERP RCG/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	454	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE		001 MNR RC 002 01 003 BL02	
26	455	AXLE ID & LOWER END PISTON ID REPAIR GARNET BLAST TO CLEAN-UP CORROSION. 200-511-1/001501. *C/P MOVE		001 MNR RC 002 01 003 SL02	
26	460	CAD PLATE TYPE II CLASS 2 1.9 SQ FT AT 95-133 AMPS TIME OUT _____ DATE OUT _____ *C/P MOVE		001 MNR RC 002 03 003 CA03	
26B	470	BAKE 23 HRS WITHIN 4 HRS OF CAD DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNR RC 002 02 003 BK01	
26	480	IRIDIUM *C/P MOVE		001 MNR RC 002 02 003 IR01	
	.65	***** NOTE ***** IF LAST NOT OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *****	M	001 MNR NA 002 06 003 ML04	
26	486	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 470 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION. *C/P MOVE		001 MNR RC 002 03 003 IVD1	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCG SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	15501N	
		B	D		

15501N

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

89038

PAGE 1 OF 1 PAGES

1. JOB ORDER NO.	2. QUANTITY	3. PRODUCTION SEC/RCC	4. DATE SCHED.	5. DATE COMPLETED
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6. PART NUMBER	7. TECH DATA	8. ITEM SERIAL NO.
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9. MODEL-DESIGN-SERIES	10. STOCK NUMBER	11. OPTIONAL
12. SERIAL NUMBER	13. NOUN PISTON	

14. DISPATCH STATION	15. PERF RCC/OP NO.	16. WORK TO BE ACCOMPLISHED	17. MECHANIC	18. "P"	19. "Q"
26	487	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNPFC 002 02 003 1A01	
69	488	MACHINE TORQUE ARM BOSS FLANGE BUSHING.		001 MNPFC 002 02 003 LE02	
69	490	TORQUE ARM BOSS "FLANGE" BUSHING REPAIR 1.375/1.380 FACE TO FACE *C/P MOVE		001 MNPFC 002 04 003 1E01	
69	498	MACHINE TORQUE ARM BUSHING P/N 65A30315-10		001 MNPFC 002 04 003 LE02	
69	500	TORQUE ARM BOSS BUSHING INSTALLATION P/N 65A30315-10 PRESS FIT .0005/.0015 FINISH LINE REAM BUSHING ID 1.001/1.002 USE A 65A30315 OR BUSHING WHEN -10 DEPLETES *C/P MOVE		001 MNPFC 002 04 003 LE01	
69	510	REPLACE SHOULDER BLOCKS *C/P MOVE		001 MNPFC 002 04 003 BE01	
	520	PAINT ID OF AXLE WITH POLYURETHANE PER T.O. *REQD* *C/P MOVE		001 MNPFC 002 09 003 PP01	
	530	FINAL ACC PTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958		001 MNPFC 002 06 003 SA03	
	540	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD*		001 MNPFC 002 06 003 SA03	

20. FINAL DESTINATION		21. COORDINATION/INITIATING RCC SIGNATURE/DATE		22. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	15501N

APIC FORM 988 NOV 80

PREVIOUS EDITION WILL BE USED

340

15503N

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

39038

PAGE 1 OF 1 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
		4NPGP		
7. PART NUMBER	8. TECH DATA		9. ITEM SERIAL NO.	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
KC135 NOSE		00-20-5 17567A 452-30-3 69354A 45-1-182 17567A
13. SERIAL NUMBER	14. NGUN	
	NUT UPPER OLED	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
60-668		NSL 17567A	69354A		
60-668		NSL 17567A			
60-668 -1		5310010153748 69354A	17567A		
60-668 -1		5310010206440 17567A	69354A		
60-668 -2		5310010206440 69354A			
60-668 -2					

GOVERNING DIRECTIVES: AFM 66-51  
MANUAL 66-3  
FMP1 IAW MIL-STD-194

SHO1 PEEN IAW MIL-S-10165

\*\*\*\*\*UNIT COST \$ 350.99\*\*\*\*\*  
\*\*\*\*\*UNIT L 4150 (125/145 KSI)\*\*\*\*\*

ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFM FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.

\*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.

## WARNING

MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/EN
DISPATCH	FUNCTIONAL CODE	A		15503N

15503N

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

89038

PAGE 2 OF 2 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCT ID - SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
7. PART NUMBER	8. TECH DATA		9. ITEM SERIAL NO.	

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NGUN NUT UPPER OLED	

15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURES.			
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	60-6681 60-6681-1 60-6681-2			
	005	DISASSEMBLE *REQD* *C/P MOVE		001 MNP GW 002 02 003 LG02 004 Y8745202 006 Y8745138	
	006	DECREASE ONLY *C/P MOVE *REQD*		001 MNP GW 002 02 003 0002	
		*C/P MOVE *REQD*	M	001 MNP RA 002 05 003 MS03	
24E	025	E & I **NOTE: ROUTE FOR REPAIR IF CRACKED *REQD* *C/P MOVE		001 MNP GW 002 04 003 EI01	
	030	REMOVE CRACKS FOUND IN SLOTS IAW PAGE 6-33 PARA "K" MAX. WIDTH OF SLOT AFTER REWORK NOT TO EXCEED .440 MAX .845 FROM BOTTOM OF NUT .845 ALL EDGES RADIUS .03/.06 32 RMS *C/P MOVE		001 MNP RA 002 04 003 MV00	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	15503N



15504N

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

89038

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
		ANPBP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	45-1-182	

10. MODEL/DESIGN/SERIES	11. STOCK NUMBER	12. OPTIONAL
KC135 NOSE		
13. SERIAL NUMBER	14. NOUN	
	ACTUATOR BRACKET	

17567A  
69354A

15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 5-7234		NSN C/N 162000908935 17567A 59354A			
		***** UNIT COST \$121.72 ***** GOVERNING DIRECTIVES: AFMCR 66-51 MANOI 66-3			
		PFI 1AW MIL-STD-883C STRIP 1AW MIL-STD-883C ANGLIZE 1AW MIL-A-8625 BLAST 1AW MIL-STD-1504			
		*****ALUMINUM 7075-T6*****			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO			
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA			

21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/ON
DISPATCH FUNCTIONAL CODE	A	15504N





5504N

## WORK CONTROL DOCUMENT (MEDL)

1. DATE

87038

PAGE 3 OF 4 PAGES

JOB ORDER NO.

2. QUANTITY

4. PRODUCTION SEC/RC

5. DATE SCHED.

6. DATE COMPLETED

PART NUMBER

7. TECH DATA

8. ITEM SERIAL NO.

MODEL DESIGN SERIES

11. STOCK NUMBER

12. OPTIONAL

SERIAL NUMBER

14. NSUN

ACTUATOR BRACKET

10. DISPATCH TATION	13. PERP REC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
✓	040	DRILL AND LINE REAM NEW ACTUATOR BRACKET TRUNNION HOLES UPPER ID .625/.625 TRUNNION HOLES LOWER ID .625/.625 63 RMS *C/P MOVE		001 MNHRA 002 04 003 BE01	
✓	045	SPOT ALODINE MINOR REWORK *C/P MOVE		001 MNHRA 002 04 003 BE01	
✓	050	ACTUATOR ATTACH HOLE SINGLE OVERSIZE TO CLEAN UP ID 1.00 MAX 63 RMS *C/P MOVE		001 MNHRA 002 04 003 BE01	
✓	060	TRUNNION ATTACH HOLES UPPER OVERSIZE TO CLEAN UP ID .8129 MAX O/S 63RMS *C/P MOVE		001 MNHRA 002 04 003 BE01	
✓	070	TRUNNION ATTACH HOLES LOWER OVERSIZE TO CLEAN UP ID .6879 MAX O/S 63RMS *C/P MOVE		001 MNHRA 002 04 003 BE01	
✓	080	STRIP ANODIZE *C/P MOVE		001 MNHRC 002 03 003 AN03	
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. * *****	M	001 MNHNA 002 06 003 ZA02	
6	090	ANODIZE TYPE II *C/P MOVE		001 MNHRC 002 03 003 AS03	

1. DISPATCH DESTINATION

DISPATCH

FUNCTIONAL

22.

COORDINATION/INITIATING REC SIGNATURE/DATE

23. DOCUMENT/EN

15504N

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15504N WORK CONTROL DOCUMENT (MEDS)				1. DATE 59038		PAGE 4 OF 4 PAGES	
2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/ACC		5. DATE SCHED.	
7. PART NUMBER		8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL DESIGN SERIES		11. STOCK NUMBER		12. OPTIONAL			
13. SERIAL NUMBER		14. NSUN					
		ACTUATOR BRACKET					
15. DISPATCH STATION	16. PERF ACC/OP NO.	17. WORK TO BE ACCOMPLISHED			18. MECHANIC	19. "P"	20. "Q"
69	100	MACHINE ACTUATOR ATTACH HOLE BUSHING P/N 65A30315-7A OR P/N 65A30315-7B ACTUATOR ATTACH HOLE SINGLE BUSHING INSTALLATION P/N 65A30315-7A OR -7B PRESS FIT .0005/.002 FINISH LINE REAM .875/.875 53 RMS *C/P MOVE				001 MNA 002 04 003 LE	
69	108	MACHINE TRUNNION ATTACH HOLE UPPER BUSHING P/N NAS537810P-42 OR P/N NAS537810P-104				001 MNA 002 04 003 LE	
69	110	TRUNNION ATTACH HOLE UPPER BUSHING INSTALLATION P/N NAS537810P-42 OR P-104 PRESS FIT .0005/.0017 FINISH LINE REAM ID .820/.825 53 RMS *C/P MOVE				001 MNA 002 04 003 LE	
69	118	MACHINE TRUNNION ATTACH HOLE LOWER BUSHING P/N NAS53789P-25 OR P/N NAS53789P-33				001 MNA 002 04 003 LE	
69	120	TRUNNION ATTACH HOLE LOWER BUSHING INSTALLATION P/N NAS53789P-75 & -33 PRESS FIT .0005/.0017 FINISH LINE REAM ID .563/.564 54 RMS *C/P MOVE				001 MNA 002 04 003 BE	
	170	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *REQD*				001 MNA 002 06 003 SA	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE			23. DOCUMENT/BN		
DISPATCH	FUNCTIONAL				15504N		

PAGE 2 OF 3 PAGES

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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17. DISPATCH STATION	18. PERF ACC/OP NO.	19. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
	180	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNE/OP 002 06 003 SA03	
	*REQD*				

[illegible]

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	B	
				15504N
				346

## 15509N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89038

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/ACC	5. DATE SCHED.	6. DATE COMPLETED
		MNPGP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	45-1-182	

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. DATE OF TEST
KC135 NOSE		

13. SERIAL NUMBER	14. NSN
	STEERING PLATES

15. DISPATCH STATION	16. PERF ACC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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P/N	NSN	C/N
5-73193	1620007729657	17567A
5-73193-1	1620007729658	69354A

GOVERNING DIRECTIVES: AFMCR 66-51

MANCI 66-3

BLAST

IAW MIL-STD-1504

FPI

IAW MIL-STD-883C

STRIP

IAW MIL-STD-871

ANDDIZE

IAW MIL-A-8625

CHEM FILM

IAW MIL-C-5541

SMOKEPEN

IAW MIL-S-88165

\*\*\*\*\*MAT'L 7075S-T6 ALUMINUM\*\*\*\*\*

\*\*\*\*\*UNIT COST \$ 236.90\*\*\*\*\*

\*\* ALUMINUM \*\*

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\*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.

## WARNING

MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND

21. FINAL DESTINATION		22. COORDINATION/INITIATING ACC SIGNATURE/DATE		23. DOCUMENT/ON
DISPATCH	FUNCTIONAL			15509N

15509N WORK CONTROL DOCUMENT (MEDS)				1. DATE 89038		PAGE 2 OF 2 PAGES	
2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.	
7. PART NUMBER		8. TECH DATA				9. ITEM SERIAL NO.	
13. SERIAL NUMBER		14. NGUN STEERING PLATES		12. OPTIONAL			
15. DISPATCH STATION		16. PERM ACC/OP NO.		17. WORK TO BE ACCOMPLISHED		18. MECHANIC	
						19. "P"	
						20. "Q"	
				PERCAUTIONS MUST BE EMPLOYED TO PERCLUDE INJURIES.			
				*REQD* (TEMPERARY REQUIREMENT) IN COLUMN 15 IS EQUIVALENT TO DELTA STAMP.			
		001	5-73193 5-73193-1				
34D		005	DISASSEMBLE	*C/P MOVE			001 MNPBW 002 02 003 LG02 005 X8745108 006 X8745108
		*REQD*					
34C		007	CHEM CLEAN	*C/P MOVE			001 MNPBW 002 03 003 AC02
		*REQD*					
34B		009	BLAST CLEAN ONLY	*C/P MOVE			001 MNPBW 002 03 003 BL01
		*REQD*					
				*C/P MOVE		M	001 MNPBW 002 05 003 ZY05
		*REQD*					
34A		020	E & I INSPECTION				001 MNPBW 002 04 003 E101
		*REQD*	LARGE HOLES ID 4.000/4.001				
			SMALL ATTACH HOLES ID .750/.751				
			BASE METAL - SMALL ATTACH HOLES				

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C		
				15509N	

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.	
7. PART NUMBER		8. TECH DATA				6. DATE COMPLETED	
10. MODEL-DESIGN-SERIES		11. STOCK NUMBER		12. OPTIONAL			
13. SERIAL NUMBER		14. NAME					
		STEERING PLATES					
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED			18. MECHANIC	19. "P"	20. "Q"
		REWORK TO MIN .812 MAX .928 SMALL ATTACH POLES BUSHING I.D. .750/.751 *C/P MOVE					
69	030	MODIFICATION OF SUPPORT PLATE COUNTER BORE BEARING HOLES TO I.D. 4.000/4.001 LEAVING A .180/.170 LIP AT BOTTOM. ENLARGE ATTACH POLES TO I.D. .750/.751 *C/P MOVE				001 MNFRA 002 04 003 MV02 005 03 11501	
69	032	MACHINE .219 RADIUS IF CRACKS APPEAR IN SLOT AREAS IAW PRINT 5-73193 *C/P MOVE*				001 MNFRA 002 04 003 BE01	
69	035	MACHINE RADIUS I.A.W. PRINT 5-73193 REF. B 4 PLACES FOR EACH PLATE *C/P MOVE				001 MNFRA 002 04 003 BE01	
69	040	BORE/REAM SMALL ATTACH HOLES TO MIN .812 MAX .928 COUNTER SINK HOLES PER T.D. *C/P MOVE				001 MNFRA 002 04 003 MV02 005 X8899606	
26	050	STRIP ANODIZE *C/P MOVE				001 MNFRC 002 03 003 AN04	
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *****			M	001 MNFNA 002 06 003 ZA02	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE			23. DOCUMENT/SN		
DISPATCH	FUNCTIONAL CODE				15509N		

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.	
7. PART NUMBER		8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES		11. STOCK NUMBER		12. OPTIONAL			
13. SERIAL NUMBER		14. NOUN STEERING PLATES					
15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED			18. MECHANIC	19. "P"	20. "Q"
26	058	SHOT-PEEN LOCAL REWORK ON LUG EARS 100% .004/.010A INTENSITY LAW PAGE 6-7 FIG 6-2 NOTE "F" C/P MOVE*				001 MNPRC 002 01 003 SP01	
26	060	HARD ANODIZE OVERSIZED LARGE BEARING HOLES TYPE III MIL-A-8625 4.000/4.002 *C/P MOVE				001 MNPRC 002 03 003 AH01	
26	065	ANODIZE STEERING PLATE TYPE II *C/P MOVE				001 MNPRC 002 03 003 AS03	
69	068	MACHINE BUSHING .0005/.0015 PRESS FIT BRUSH CADMIUM PLATE O.D. PER MIL-STD-865 P/N NAG557B12P-21				001 MNHRA 002 04 003 LE02	
69	069	INSTALL BUSHING WITH MIL-S-81733 SEALER				001 MNHRA 002 04 003 BE01	
69	070	LINE BORE BUSHING ID TO .750/.751 COUNTERSINK 110 DEGREES X .21 INCH *C/P MOVE				001 MNHRA 002 04 003 MV02	
		NOTE: SOME NOSE BEAR STEERING SUPPORT PLATES CONTAIN UNDERSIZE HOLES. THESE HOLES MUST BE MACHINED TO SIZE & LOCATED TO MATCH HOLES IN OLD PLATE TO PREVENT BINDING OF STEERING ACTUATOR.					
		A. MACHINE MOUNTING HOLES TO .750/.751 COUNTERSINK HOLES 110 DEGREES X .21 INCH COUNTERSINK HOLES ON THE SIDE BOLT IS INSTALLED FROM. COUNTERSINK UPPER PLATE 5-73193 ON BOTTOM. COUNTERSINK LOWER PLATE 5-73193-1 ON TOP.					
		B. COUNTERBORE BEARING HOLE 4.000/4.001 (CONTINUED)					
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN			
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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
7. PART NUMBER	8. TECH DATA		9. ITEM SERIAL NO.	

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN STEERING PLATES	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		C. LEAVE .18 / 12 IN THICK SHOULDER TO ACCOMMODATE BEARING.			
		D. CHAMFER EDGE OF COUNTERBORE TO 45 DEG. 1/8 X 1/8 IN.			
		E. RADIUS INTERNAL 100 / 0.0102 IN.			
		F. MACHINE UPPER PLATE WITH 1/8 IN. UP			
		G. MACHINE LOWER PLATE WITH 1/8 IN. DOWN *C/P MOVE			
		[REDACTED] *C/P MOVE		001 MNRCC 002 06 003 ZR 2	
26	084	SHOTPEEN BEARING HOLES .009 TO .010A2 INTENSITY 100 PERCENT COVERAGE *C/P MOVE		001 MNRCC 002 01 003 SP01	
26	090	ALODINE REWORKED *C/P MOVE		001 MNRCC 002 03 003 TA01	
	100	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958		001 MNRCC 002 06 003 SA03	
	110	FINAL PRODUCT VISUAL INSPECTION *REQD* *C/P MOVE		001 MNRCC 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	15509N



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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
				MM DD		
7. PART NUMBER			8. TECH DATA		9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER		12. OPTIONAL	
K0135 NL-E					11-20-8 48-1-142 482-50-8	
13. SERIAL NUMBER			14. NOUN		17567A 69354A	
			BLEED CAN JPL & 1.0WAK			
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED			18. MECHANIC	19. "P"
P/N		NSN				
158661		1620005934049				
5-93012-1		69354A				
		GOVERNING DIRECTIVES				
		AFM 66-5				
		MANU 65-3				
		BLAST				
		IAW MIL-STD-150				
		PART				
		270 0013				
		B.P.P.				
		IAW MIL-STD-150				
		PART				
		100 0013				
		SIGHT LHD				
		IAW MIL-STD-150				
		PART				
		100 0013				
		WARNING				
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO				
(CONTINUED)						
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE			23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE				15510N	
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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE RCHED	6. DATE COMPLETED	
7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO.	
10. MODEL DESIGN SERIES		11. STOCK NUMBER	12. OPTIONAL		
13. SERIAL NUMBER		14. NOUN			
		OLEO LAY UPPER & LOWER			
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		VISUAL 311-111-111 *C/P MOVE			
	020	CLEANLY & VISIBLY ALL AREAS REMOVE RIVETS & NUTS & SCREWS *C/P MOVE		001 MM L W 002 04 003 BL01	
69	058	MODIFY CAM I.A.W. 452-30-3 PAGE 6-9 P/N 5-83010-1 *C/P MOVE		001 MM L W 002 04 003 BL01	
69	060	MODIFY CAM IAW 452-30-3 PAGE 6-9 PARA. 6-6 REIDENTIFY P/N 5-83012-1 *C/P MOVE		001 MM L W 002 04 003 BL01	
		*C/P MOVE ***** IF LAMP ASSEMBLY IS COMPLETED HERE, ***** *****		001 MM L W 002 04 003 BL01	
26	073	VAPOR 111-111-111 *C/P MOVE		001 MM L W 002 03 003 BL01	
26	077	PRIOR TO PHOSPHATE, SPIT BLAST ALL AREAS TO BE PHOSPHATE COATED. *C/P MOVE		001 MM L W 002 01 003 BL02	
26	080	PHOSPHATE LUSTING TYPE M CLASS 21 ALL SURFACES ON UPPER, ALL SURFACES BUT RAMPS ON THE LOWER IAW FIG 6-1 PAGE 6-2 *C/P MOVE		001 MM L W 002 03 003 PH01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOC. VENT/EN	
DISPATCH	FUNCTIONAL CODE	A	C	155.0N	

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2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13. SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES							
		MAINTAIN A 32 RMS FINISH ON ALL REWORKED SURFACES							
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	7327022-30							
34D	005 *REQD*	DISASSEMBLE *C/P MOVE					001 MNP GW 002 02 003 LG02 005 X8745233 006 X8745188		
34C	007 *REQD*	CHEM CLEAN *C/P MOVE					001 MNP GW 002 03 003 AC02		
34B	009 *REQD*	BLAST CLEAN ONLY *C/P MOVE					001 MNP GW 002 03 003 BL01		
		*C/P MOVE				M	001 MNP NA 002 05 003 ZY05		
34E	050 *REQD*	E & I AND ROUTE DRAG BRACE LUG BASE HOLE 1.750/1.752 (CONTINUED)					001 MNP GW 002 04 003 EI01		
21. FINAL DESTINATION DISPATCH		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN					
FUNCTIONAL CODE		A		15512N					

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
7. PART NUMBER	8. TECH DATA			9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN OUTER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DRAG BRACE BUSHING I.D. 1.500/1.501 OVERALL 3.497/3.499 TRUNNION BORES 2.250/2.251			
		TRUNNION RETAINING PIN HOLES .438/.440			
		ACTUATOR BRACKET LUGS			
		J .625/.626 K .563/.564			
		STEERING PLATE LUG HOLES .750/.751			
		STEERING COLLAR AREA			
		WIDTH 3.352/3.355 O.D. 7.118/7.120 TOWING COLLAR AREA WIDTH 2.228/2.230			
		O.D. 7.118/7.120 UPPER SEAL AREA BORE APP 206 WIDTH STD SIZE I.D. 5.502/5.504 UPPER BEARING BORE-STD 5.625/5.630			
		1ST OVERSIZE 5.680/5.685 LOWER BEARING BORE STD 5.875/5.877 1ST OVERSIZE 5.915/5.920			
		DOOR ATTACH LUGS .312/.315			
		INTERNAL DEFECTS LESS THAN .006 IN DEPTH ARE SATISFACTORY WITHOUT REMOVAL PROVIDED THEY ARE NOT IN THE UPPER OR LOWER SEAL AREA OR CLOSER THAN 1 IN. APART.			
		NOTE: DO NOT STRIP HARD ANODIZE UNLESS DEFECTS EXCEED .006 OR DAMAGE IS IN THE SEAL AREA REFER TO 6-15 (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	B	15512N

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OUTER CYLINDER						
18. DISPATCH STATION	19. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		FOR ADDITIONAL LIMITS *C/P MOVE							
		NOTE: IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL REWORK MUST BE ACCOMPLISHED.							
		*C/P MOVE							
69	052	NICK & BURR OUTER *C/P MOVE*					001 MNPRA 002 04 003 BE01		
69	055	REMOVE BUSHINGS IF NECESSARY *C/P MOVE					001 MNPRA 002 04 003 BE01		
26	060	STRIP ANODIZE O.D. TYPE 2 ONLY *C/P MOVE					001 MNPRA 002 03 003 AN04		
26	064	STRIP HARD ANODIZE I.D. TYPE 3 ONLY ON 7327022 CYLINDER FOR O/S REPAIR OR WHEN INTERNAL DEFECTS EXCEED .006 IN DEPTH *C/P MOVE					001 MNPRA 002 03 003 AN04		
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *****				M	001 MNPRA 002 06 003 ZA02		
69	070	DRAG BRACE HOLE REPAIR O/S AS REQUIRED TO CLEAN UP MIN 1.753 TO MAX 1.850 *C/P MOVE					001 MNPRA 002 04 003 MH02 005 XB33611		
69	080	TRUNNION BORE 1ST REPAIR PITS OVER .006 MAYBE REWORKED IF LESS THAN 20% OF SOCKET IS EFFECTED. MAX REWORK (CONTINUED)					001 MNPRA 002 04 003 MH02 005 XB33611		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				15512N			
		B							
		C							

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2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.
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10 MODEL DESIGN SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN OUTER CYLINDER	

15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
		.015 REQUIRES SHOT PEEN & ALODINE *C/P MOVE			
69	082	TRUNNION BORE 2ND REPAIR O/S AS REQUIRED TO CLEAN UP MIN 2.330 TO MAX 2.500 *C/P MOVE		001 MNPRA 002 04 003 MH02 005 X8533611	
69	090	TRUNNION RETAINING PIN HOLE REPAIR OVERSIZE TO CLEANUP .500/.501 *C/P MOVE		001 MNPRA 002 04 003 MH02 005 X8533611	
69	095	ROLL BURNISH TO .502/.503 AND ALODINE *C/P MOVE		001 MNPRA 002 04 003 BE01	
69	100	ACTUATOR BRACKET HOLE REPAIR (J) O/S TO CLEANUP AS REQUIRED MAX O/S .8129 *C/P MOVE		001 MNPRA 002 04 003 BE01	
69	105	DOOR LUG HOLE REPAIR OVERSIZE TO .370/.372 *C/P MOVE		001 MNPRA 002 04 003 BE01	
69	110	ACTUATOR BRACKET HOLE REPAIR (K) O/S TO CLEANUP AS REQUIRED MAX O/S .6879 *C/P MOVE		001 MNPRA 002 04 003 BE01	
69	120	STEERING PLATE LUG HOLE REPAIR O/S TO CLEANUP AS REQUIRED MAX O/S .9379 *C/P MOVE		001 MNPRA 002 04 003 BE01 005 X8120881	
69	130	STEERING COLLAR REPAIR 1ST REPAIR PITS DEEPER THAN .006 MAY BE LOCALLY POLISHED TO DEPTH OF .050 INCH OVER 50% OF ANY ONE SQ INCH AREA BLEND REWORKED AREA WITH RUN OUT 5 TIMES THE DEPTH OF REWORK *C/P MOVE		001 MNPRA 002 04 003 BE01	

21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/BN
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7. PART NUMBER	8. TECH DATA			9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN OUTER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	140	TOWING COLLAR REPAIR PITS DEEPER THAN .006 MAY BE LOCALLY POLISHED TO DEPTH OF .050 INCH OVER 50% OF ANY ONES SQ INCH AREA		001 MNPRA 002 04 003 BE01	
		BLEND REWORKED AREA WITH RUN OUT 5 TIMES THE DEPTH OF REWORK *C/P MOVE			
69	145	STEERING COLLAR AREA 2ND REPAIR FOR FLAME SPRAY MACHINE TO REMOVE CORROSION OR DAMAGE NOT TO EXCEED 6.940 OD 3.515 WIDTH *C/P MOVE		001 MNPRA 002 04 003 LE07	
69	146	TOWING COLLAR AREA 2ND REPAIR FOR FLAME SPRAY MACHINE TO REMOVE CORROSION OR DAMAGE NOT TO EXCEED 6.940 OD 2.430 WIDTH *C/P MOVE		001 MNPRA 002 04 003 LE07	
8	150	I.D. REWORK ON BASE METAL DRESS OUT LONGTUDINAL DEFECTS MAX. LENGTH 4 IN. MIN. RADIUS 1 TO 2 IN. SEE FIG. 6-7 FOUR EACH ALLOWED		001 MNPRA 002 01 003 BE01	
		ONE ELEVATION 60 DEG. APART *C/P MOVE			
8	151	I.D. REWORK ON BASE METAL DRESS OUT CIRCUMFERENTIAL DEFECTS MAX. LENGTH 2 IN. RADIUS 1 TO 2 IN. AT ANY ONE ELEVATION ONLY CIRCUMFERENTIAL (LATERAL) IRREGULARITY SHALL BE DRESSED OUT SEE FIG. 6-8 FOR ADDITIONAL DRESS OUTS *C/P MOVE		001 MNPRA 002 01 003 BE01	
8	152	HONE UPPER SEAL AREA BORE, LOCATED BETWEEN 36.10 INCHES AND 37.35 INCHES ABOVE LWR END OF CYL MAY BE REWORKED NOT TO EXCEED 5.522 I.D. *C/P MOVE		001 MNPRA 002 01 003 HV03 005 X8745246	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/EN
DISPATCH	FUNCTIONAL CODE	A	B	15512N

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.		

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN OUTER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
8	153	IRREGULARITIES MAY BE DRESSED OUT TO .006 INCHES MAX ON A SIDE, PROVIDED THE MAX 5.522 ID IS NOT EXCEEDED 2 INCH MIN RADIUS SHALL BE MAINTAINED AT EDGE OF DRESS OUT .63 RMS OR BETTER RECORD BASE METAL DIMENSION----- *C/P MOVE		001 MNPRB 002 01 003 BE01	
8	154	HONE STD REPAIR UPPER BEARING BORE 5.625/5.630 HONE IAW PAGE 6-16 PARG "I" T.O. 4S2-30-3 125RMS RECORD DIMENSIONS----- C/P MOVE		001 MNPRB 002 01 003 HV03 005 X8745246	
8	155	HONE 1ST REPAIR UPPER BEARING BORE 5.680/5.685 REIDENTIFY IAW T.O. 4S2-30-3 PAGE 6-19 PARG "N" 125RMS RECORD DIMENSIONS----- *C/P MOVE*		001 MNPRB 002 01 003 HV03 005 X8745246	
8	156	HONE STD SIZE LOWER BEARING BORE 5.875/5.877 ID TO CLEAN-UP NOT TO EXCEED WEAR 5.893 125 RMS RECORD BASE METAL DIMENSION----- *C/P MOVE*		001 MNPRB 002 01 003 HV03 005 X8745246	
8	158	HONE 1ST REPAIR LOWER BEARING BORE NOT TO EXCEED 5.920 MAX. REIDENTIFY IAW 4S2-30-3 PAGE 6-19 PARG "N" 125RMS RECORD DIMENSIONS----- *C/P MOVE*		001 MNPRB 002 01 003 HV03 005 X8745246	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	E	15512N

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7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26	170	VAPOR DEGREASE *C/P MOVE						001 MNP RC 002 03 003 DGO1	
		*C/P MOVE * * * * * N O T E * * * * * IF LAST MTL OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. * * * * *				M		001 MNP RA 002 06 003 ZAO2	
26	180	SHOT PEEN OUTER CYLINDER REWORK AREAS .010/.014 *C/P MOVE						001 MNP RC 002 01 003 SP01	
26	183	SHOT-PEEN I.D. FOR ANODIZE .010/.014 INTENSITY *C/P MOVE						001 MNP RC 002 01 003 SP01	
26	185	SHOT-PEEN TRUNNION SOCKET HOLES I.D. 100% 2.250 HOLES *C/P MOVE*						001 MNP RC 002 01 003 SP01	
26	190	CLEAN SHOT PEENED AREAS OF OUTER & SOCKET *C/P MOVE						001 MNP RC 002 01 003 BE01	
26	200	POLISH STEERING COLLAR AREAS TO REMOVE 70-80% OF SHOT *C/P MOVE						001 MNP RC 002 03 003 BE01	
26	210	POLISH TOW LUG AREA TO REMOVE 70-80% OF SHOT *C/P MOVE						001 MNP RC 002 03 003 BE01	
25B	212							001 MNP JW 002 08 003 DGO1	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/EN			
DISPATCH		FUNCTIONAL		A		B		15512N	

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
7. PART NUMBER	8. TECH DATA			9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN OUTER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
25B	213	[REDACTED] *C/P MOVE		001 MNPWW 002 08 003 BE01	
25B	214	[REDACTED] *C/P MOVE		001 MNPWW 002 08 003 BL01	
25B	215	[REDACTED]		001 MNPWW 002 08 003 FS04 005 YB929467	
25B	220	[REDACTED]		001 MNPWW 002 08 003 FS04 005 YB929467	
25B	222	[REDACTED]		001 MNPWW 002 08 003 FS04	
25B	224	[REDACTED]		001 MNPWW 002 08 003 FS04	
69	225	MACHINE STEERING COLLAR AREA 7.118/7.120 OD 3.352/3.355 WIDTH 63 RMS FINISH *C/P MOVE		001 MNPRA 002 04 003 LE07	
69	228	MACHINE TOWING COLLAR AREA 7.118/7.120 OD 2.228/2.230 WIDTH 63 RMS FINISH *C/P MOVE		001 MNPRA 002 04 003 LE07	
26	230	ANODIZE OUTER CYLINDER TYPE II O.D. ONLY *C/P MOVE		001 MNPRC 002 03 003 AS03	
26	232	ANODIZE OUTER CYL TYPE II COMPLETE ID & OD. *C/P MOVE		001 MNPRC 002 03 003 AS03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	15512N

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN OUTER CYLINDER	

15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
8	234	HONE UPPER SEAL BORE TO REMOVE TYPE II ANODIZE 32 RMS 5.522 MAX		001 MNPRB 002 01 003 HV03 005 X8745244	
8	236	POLISH UPPER SEAL BORE TO REMOVE TYPE II ANODIZE 32 RMS 5.522 MAX		001 MNPRB 002 01 003 BE01	
8	238	HONE UPPER BORE TO REMOVE TYPE II ANODIZE 32 RMS 5.685 MAX		001 MNPRB 002 01 003 HV03 005 X8745244	
8	240	POLISH UPPER BORE TO REMOVE TYPE II ANODIZE 32 RMS 5.685 MAX		001 MNPRB 002 01 003 BE01	
8	242	HONE LOWER BORE TO REMOVE TYPE II ANODIZE 32 RMS 5.920 MAX		001 MNPRB 002 01 003 HV03 005 X8745244	
8	244	POLISH LOWER BORE TO REMOVE TYPE II ANODIZE 32 RMS 5.920 MAX		001 MNPRB 002 01 003 BE01	
26	245	HARD ANODIZE TYPE III I.D. ONLY MIN. 002 TO MAX .004 PER DIA. *C/P MOVE ***** N O T E *****		001 MNPRC 002 03 003 AH01 008 AT010	
		ALL HOLES TO BE PLUGGED BEFORE HARD ANODIZE			
8	250	FINAL POLISH UPPER SEAL BORE STD 5.502/5.504 63 RMS 5.522 MAX *C/P MOVE		001 MNPRB 002 01 003 BE01	
8	255	FINAL POLISH UPPER BORE STD SIZE 5.625/5.630 1ST O/S 5.680/5.685 63 RMS *C/P MOVE		001 MNPRB 002 01 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN OUTER CYLINDER	

15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
B	258	FINAL POLISH LOWER BORE STD SIZE 5.875/5.877 63 RMS 5.893 MAX		001 MNPRB 002 01 003 BE01	
B	260	REIDENTIFY OUTER CYLINDERS WITH O/S BORES IAW PAGE 6-19, PAR. "N" C/P MOVE		001 MNPRB 002 01 003 BE01	
26	265	ALODINE MINOR REWORK AREAS C/P MOVE		001 MNPRC 002 03 003 TA01	
69	268	MACHINE DRAG BRACE HOLE BUSHING P/N 63-2030-1 P/N 63-2030-2		001 MNPRA 002 04 003 LE02	
69	270	DRAG BRACE HOLE BUSHING INSTALLATION P/N 63-2030-1/63-2030-2 PRESS FIT .0005/.0015 LINE REAM 1.500/1.501 OVERALL 3.497/3.499		001 MNPRA 002 04 003 BE01	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
69	278	MACHINE TRUNNION HOLE BUSHING P/N 65B32580-01 P/N 65B32580-03		001 MNPRA 002 04 003 LE02	
69	280	TRUNNION HOLE BUSHING INSTALLATION INSTALL BUSH 65B32580-01 OR -03 I.D. DIM. 2.250/2.251 .110/.120 BELOW BORE FACE *C/P MOVE* PRESS FIT .0005/.0005		001 MNPRA 002 04 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15512N

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO.

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN OUTER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	281	CENTER DRILL TRUNNION RETAINING PIN HOLE .406/.423 INSTALL TRUNNION AND LINE REAM RETAINING PIN HOLES TO .436/.430 *C/P MOVE		001 MNPRA 002 04 003 BE01	
69	290	MACH TRUNNION RETAINING PIN BUSHING P/N 68J29645-61S32P FLUSH TO .005 BELDW CYLINDER SURFACE INSIDE FINISH TO .438/.440 PRESS FIT TO .001/.0015		001 MNPRA 002 04 003 LE02	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 68J29645-61S32P			
69	291	MACHINE STEERING PLATE LUG BUSHING P/N NAS537B12P-43		001 MNPRA 002 04 003 LE02	
69	292	STEERING PLATE LUG BUSHING INSTALLATION P/N NAS537B12P-43 LINE REAM .750/.751 PRESS FIT .0006/.002		001 MNPRA 002 04 003 BE01	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
69	293	MACHINE ACTUATOR BRACKER HOLE (J) BUSHING P/N NAS537B10P-86		001 MNPRA 002 04 003 LE02	
69	295	ACTUATOR BRACKET HOLE (J) BUSHING INSTALLATION P/N NAS537B10P-86 PRESS FIT .0005/.0015 FINISH LINE REAM		001 MNPRA 002 04 003 BE01	

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
7. PART NUMBER	8. TECH DATA			9. ITEM SERIAL NO.

10. MODEL DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN OUTER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		ID .625/.626  RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED  RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
69	296	MACHINE ACTUATOR BRACKET HOLES (K) BUSHING. P/N NAS537B9P-61		001 MNPRA 002 04 003 LE02	
69	297	ACTUATOR BRACKET HOLES (K) BUSHING INSTALLATION P/N NAS537B9P-61 PRESS FIT .0005/.0015 FINISH LINE REAM ID .563/.564  RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED  RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNPRA 002 04 003 BE01	
69	299	MACHINE DOOR ATTACH LUG BUSHINGS		001 MNPRA 002 04 003 LE02	
69	300	DOOR ATTACH LUG BUSHING .312/.316 FLUSH TO .0005 BELOW LUG FACE PRESS FIT .0003/.0012 *C/P MOVE		001 MNPRA 002 04 003 BE01	
69	310	INSTALL TRUNNION PINS *C/P MOVE		001 MNPRA 002 04 003 BE01	
69	320	REAM TRUNNION PIN LOCK SCREW HOLES .436/.440 *C/P MOVE		001 MNPRA 002 04 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/EN
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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
7. PART NUMBER	8. TECH DATA			9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN OUTER CYLINDER	

15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	330	MARK AND REMOVE TRUNNION PIN P/N 6-68001 FIG 2-3 INDEX 43 4S2-30-3 *C/P MOVE		001 MNPRA 002 04 003 BE01	
		P/N 6-68001			
69	340	INSTALL HELICOILS *C/P MOVE		001 MNPRA 002 04 003 BE01	
34PP	343 *REQD*	PRE-PAINT STEERING COLLAR JOURNALS *C/P MOVE*		001 MNP GP 002 09 003 PP01	
34A	345 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNP GP 002 06 003 SA03	
34A	350 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNP GP 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15512N
		B	D	

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC MNP GP	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA 4S-1-182 4S2-30-3	9. ITEM SERIAL NO.
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10. MODEL/DESIGN/SERIES KC-135 NOSE	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN BEARING UPPER
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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P/N 6-55002-1		NSN 1620005168897	C/N 17567A 69354A		
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		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
--	--	---	--	--	--

		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY			
--	--	---	--	--	--

		PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL			
--	--	--	--	--	--

		ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR			
--	--	--	--	--	--

		MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.  *****"W A R N I N G"*****			
--	--	--	--	--	--

		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO			
--	--	---	--	--	--

		PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
--	--	---	--	--	--

		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
--	--	---	--	--	--

		***** M I C A R T A ***** ***** UNIT COST \$50.49 *****			
--	--	--	--	--	--

21. FINAL DESTINATION DISPATCH	21. FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	22. COORDINATION/INITIATING RCC SIGNATURE/DATE C	23. DOCUMENT/BN 15514N
		B	D	

## 15514N WORK CONTROL DOCUMENT (MEDS)

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
7. PART NUMBER	8. TECH DATA			9. ITEM SERIAL NO.

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN BEARING UPPER	

15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
	001	6-55002-1			
34D	005	DISASSEMBLE *C/P MOVE		001 MNPBW	
	*REQD*			002 02	
				003 LG02	
				005 X8745233	
				006 X8745188	
34D	006	DEGREASE ONLY *C/P MOVE		001 MNPBW	
	*REQD*			002 02	
				003 DG02	
34E	020	E & I I.D 4.753/4.755 O.D 5.620/5.625 OVERSIZE O.D 5.670/5.675 C/P MOVE		001 MNPBW	
				002 04	
				003 EI01	
29	030	EPOXY O.D. RESOLIN RLF COTTON FIBER EPOXY RESIN SUFFICIENT TO MACHINE TO 5.660/5.690 *C/P MOVE		001 MNPWD	
				002 10	
				003 PL03	
69	038	MACHINE O.D. 5.670/5.675 63 RMS		001 MNPRA	
				002 04	
				003 LE02	
69	040	NICK & BURR *C/P MOVE		001 MNPRA	
				002 04	
				003 BE01	
34A	050	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPBP	
	*REQD*			002 06	
				003 SA03	
34A	060	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPBP	
	*REQD*			002 06	
				003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	15514N

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC MNP GP	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA 482-30-3/45-1-182	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES KC-135 N.L.G.	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NSN LOWER GEAR NUT	

15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 158665		NSN C/N 5365007660478LE 17567A 69354A			
		*****UNIT COST \$58.42***** GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 BLAST IAW MIL-STD-1504 BAKE IAW 48-1-182 MAOI 74-12 FMPI IAW MIL-STD-1949 P/O NO1561			
		STRIP CAD I A W MIL-STD-871 CAD PLATE I A W MIL-STD-870 VAC CAD I A W MIL-C-8837 TVD ALUM PLATE IAW MIL-C-83488A ALODINE IAW MIL-C-5541 *****S T E E L*****			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. *****"W A R N I N G"***** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO			
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	B	15517N

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL DESIGN SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN LOWER GEAR NUT						
15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN							
		BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP							
	001	158665							
34D	005 *REQD*	DISASSEMBLE *C/P MOVE					001 MNPBW 002 02 003 LC02 005 XB745233 006 XB745188		
34C	007 *REQD*	CHEM CLEAN *C/P MOVE					001 MNPBW 002 03 003 SL01		
34B	009 *REQD*	BLAST CLEAN ONLY *C/P MOVE					001 MNPBW 002 03 003 BL07		
34B	011 *REQD*	BAKE 4 HRS AT 350/400F DATE IN _____ TIME IN _____					001 MNPBW 002 03 003 BK03		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		[REDACTED] *C/P MOVE				M	001 MNPNA 002 05 003 MS03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/ON			
DISPATCH	FUNCTIONAL CODE	A				15517N			
		B							
		C							

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN LOWER GEAR NUT	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
34E	020 *REQD*	E & I VISUAL DAMAGE CHECK *C/P MOVE		001 MNPGW 002 04 003 EI01	
34E	030 *REQD*	NICK & BURR THREADS AND LOCAL DAMAGE *C/P MOVE		001 MNPGW 002 04 003 EI01	
26	032	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	034	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	036	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
26	038	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	040	VAC-CAD-PLATE TYPE II CLASS II *C/P MOVE		001 MNPRC 002 02 003 VC01	
26	050	CAD-PLATE TYPE II CLASS II *C/P MOVE		001 MNPRC 002 03 003 CA01	
26B	060	BAKE 23 HRS AT 350/400F WITHIN 4 HRS OF CAD PLATE DATE IN _____ TIME IN _____		001 MNPRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	15517N
		B	D	

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
7. PART NUMBER	8. TECH DATA			9. ITEM SERIAL NO.

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN LOWER GEAR NUT	

15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	070	IRIDITE *C/P MOVE		001 MNPRC 002 02 003 IR01	
		*C/P MOVE		001 MNPNA 002 06 003 ML04	
	.65	***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****	M		
26	083	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 060 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION. *C/P MOVE		001 MNPRC 002 03 003 IV01	
26	087	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNPRC 002 03 003 TA01	
34A	090	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGP 002 06 003 SA03	
34A	100	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD*		001 MNPGP 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	15517N
		B	D	